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# ANCHOR CONCRETE MACHINERY



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# Hand Book on Concrete Products Machinery



**Anchor Concrete Machinery Co.**

*Main Office*  
**Columbus, Ohio**      *Main Factory*  
**Adrian, Michigan**

*Cable Address:* ~ Anchor Columbus Ohio  
*Code Used:* Western Union Universal Edition

## *Guarantee*

ANCHOR machinery is sold under an absolute guarantee that if it is not entirely as represented, all payments will be refunded. There are no loopholes in this guarantee and the ANCHOR CONCRETE MACHINERY COMPANY has stood behind it for many years. Any parts found defective will be replaced free of charge for one year from date of shipment.

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## FOREWORD

BUILDING codes throughout the country are constantly being improved. Regulations covering the erection of buildings are continually becoming more stringent.

This means that building units must keep pace—they must be continually improved in quality. This applies to concrete building units as well as any other.

Rapid growth of the concrete products industry has brought success to those who turn out high grade products.

But knowing how to make good products and using the best materials will not produce them. The best equipment obtainable is also necessary.

To improve the quality of the concrete product, the machinery must be first improved. In response to this constant demand, the Anchor Concrete Machinery Company has bent every effort to make each machine in its complete and varied line better than heretofore.

For years the old Anchor Line has stood for reliable quality in concrete machinery. Neither time nor pains have been spared to make it better. Constant experiments have led to many improvements in design and construction. The result is shown in the following pages—the best concrete machinery on the market at reasonable cost.

**Anchor Concrete Machinery Co.**

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## Let's Have More Knowledge and Better Manufacturing

By HARVEY WHIPPLE

*Secretary, American Concrete Institute, and  
Editor of "Concrete" Magazine*

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**S**INCE 1920 very rapid progress has been made in establishing concrete blocks, tiles and bricks in the field of masonry building units. Only a portion of the credit for this belongs to concrete building unit manufacturers. The more extensive use of their products has been very largely an economic development from two causes: first, the very active housebuilding activity of the country; second, the scarcity and higher cost of burned clay units, bricks and tiles, due to the scarcity and high price of fuel. Rail congestion and higher freight rates have had an effect in the same direction in some localities, because in many, probably most districts, concrete building units represent local enterprise.

Manufacturers of machinery have been close on the heels of this changed situation with equipment designed for much larger production. Such machinery costs much more money than the hand outfits with which the industry started. This has had its influence in reducing the number of small operators with limited capital, and by the same cause, coupled with the greater demand for masonry materials, has tempted into the concrete products manufacturing field a type of investor who was not interested in the hazards of the business when it was overcrowded by small back yard competitors. Concrete building unit production has taken on the dignity of a real manufacturing enterprise.

### PROGRESS WAS SLOW

State the reverse of these forward conditions and you have an explanation of the comparatively slow progress of the concrete building unit manufacturing field in the preceding decade. Good concrete blocks have been made by some producers for thirty years and in a few localities these units

came very early to occupy a place of importance. Sometimes this has been due to the push and personality of the manufacturer; sometimes to the knack or judgment of some builder in using the products so that they sold themselves from the very first; sometimes a purely local economic condition in the building material field operated in favor of the unit, and in some cases building authorities were prompt in the acceptance of a building unit which promised an advantage.

Generally speaking, the concrete building unit business just "dubbed along" for years. It made a fair living for many none-too-ambitious producers; sometimes only wages. But always more and more were going into the block business, tempted by the exceptional example of the few who had made a success and lured also by the easy terms upon which a small amount of manufacturing equipment could be obtained. Of the fine points of good concrete many of these early block makers knew very little and less perhaps of those manufacturing fundamentals of productive efficiency upon which any really worth while success must depend.

### BAD BLOCKS MADE

Making concrete *seems* to be so easy and making good concrete was a thing we then knew so little about, either from a scientific or an artistic standpoint, it probably should have been no surprising result that a great many very bad concrete blocks were made, sold and used. Not only were they poor units from almost any viewpoint but they were badly used, and the result was a backlash of disapproval from almost all discriminating builders. This left the field only to cheap business. A cheap business does not attract good investors. *It is easy to cheat in making concrete block, but it doesn't pay.* With the small production equipment in use, the small market for a new and

questionable unit, with no unusual economic pressure to force its greater use, with only a few men in the business with a clear vision of its greater possibilities, the concrete building unit business, except in a few notable instances, just held its own, sometimes scarcely that much, until there emerged from a variety of causes a better combination of developing circumstances.

#### LEARNED MORE ABOUT IT

We have learned, first of all, more about making concrete. We have learned that no general statement can be made that concrete blocks, tiles and bricks are good building units or that they are not good building units. We know that their value depends on precisely what they are made of and how, and also upon how they are used after they are made. One concrete block house which is damp or cold or unsightly can remove many good business prospects. You do not find many people who are afraid to build with clay bricks, because clay bricks have given satisfactory service for some thousands of years. A cold house, a damp house, an unsightly house built of clay bricks excites no one, prejudices few. Why? Because clay bricks have established traditions and when something goes wrong it is customary to look for the cause in the way the building was erected rather than in the way the bricks were made. Clay bricks were here before we had any building laws or methods of test. People are accustomed to the idea. Gradually, very rapidly in fact of late, due to the fast moving age in which we live, concrete has been establishing traditions of its own and is making history. Elaborate series of comparative tests show us at length very convincingly that concrete units properly made are a very superior building material. It is no longer unreasonable even to general builders to suppose that concrete, with so many different kinds of successes to its credit, should be used satisfactorily for building units. That is the public frame of mind. Then the economic urgency. That is the most convincing thing. With more knowledge of concrete, a greater public acceptance of concrete, a better technical

understanding of how to make it and use it—along with these have been developed a tireless market for more building materials and the urgency placed upon the producers of machinery to give us the equipment with which to make good building units and make them fast, fast enough so that they are not cheapened in the old way, in quality, but only in price. That is how it comes about that hundreds of millions of the old traditional clay building units are being displaced by concrete building units.

#### MUCH TO BE DONE YET

We still have a great deal to accomplish in the concrete building unit field.

We must develop more uses, better uses and a more nearly standardized product.

No one should be in the business of manufacturing concrete building units until he has learned, first of all, the fundamentals of good concrete.

It is possible for a well informed architect or builder conscientiously to recommend the use of concrete blocks only when he knows whose make of blocks, unless the recommendation is coupled up with certain qualifications as to what quality of blocks to use and how to use them. That plainly indicates that we need more general adherence to standards of quality. So first of all the manufacturer himself should know more about what good concrete is, the fundamentals that remain the same with respect to concrete, whether the thing being made is a building block, a Panama Canal or a Fountain of Time.

He should begin his education, if he is new to "the concrete business," by putting out of his mind the idea that concrete is "mud," as it is often referred to on the job. Concrete—good concrete—is an engineering product, all bound 'round by chemical and physical laws which can't be successfully violated. The day has passed when the manufacturer of concrete building units can scorn the technical man who can tell him about the "water ratio" and the "fineness modulus." These are keys to the knowledge not only of how to make blocks but how to make money.



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Home of Mr. Horn, Hartford Ave. cor. Mayfield,  
Baltimore, Md. J. W. Nelson, Builder

#### CONTINUAL TESTING NEEDED

When the manufacturer gets on easy terms with these fundamentals, when he puts his materials together correctly (and by correctly we mean to make the most and best blocks for the least money) instead of throwing his profits out of the window simply by not knowing *how*; when the manufacturer gets started, he should know *all the time* how good his products are. The old monkey business of hitting a block with a hammer or throwing it on the ground is only guesswork.

Concrete products manufacturers in a large American city recently made co-operative arrangements with a testing laboratory to pick up so many samples at regular intervals (about twice a month) and tell them just exactly *how* good their products are.

In this way, by making blocks up to a recognized standard, the concrete building unit will come in time to mean *something*, not *anything*. The manufacturer should always do a little better than the building regulations require of him and adopt every legitimate means to force all manufacturers to do the same thing. That sort of thing is possible only by organized effort. Nor should products manufacturers be content to organize merely among themselves; they should be active in the study of *how to make better concrete cheaper* along with consulting engineers, contractors, architects and technical men who know that to know *how* saves money.

#### LEARN FROM OTHERS

Nobody can know today's *know how* quickly unless he is taking every opportunity to find out what other men are learning. The bigger and more successful manufacturers of concrete products are members not only of the Concrete Products Association in which they join with others of their own kind, but of the American Concrete Institute where they are among the first to enjoy a knowledge of those developments which help them to be more successful. One products manufacturer who went from New England to attend the Institute convention held in Cincinnati in January, 1923, told me he saved precisely \$1500 by what he learned from others at that meeting about the equipment needed to do a certain thing in his plant.

There is no commercial equipment made, so far as the writer knows, which uses a mix of such a consistency as to produce concrete of maximum strength. The maximum strength is not necessary. It is a question if it is desirable. There are other things besides strength to be considered. Some equipment is better than others but no equipment is of any use without a knowledge of how to get the best out of it to meet the market demands.

More demand for concrete building units is the result of economic pressure; *continued* demand will come from more and better organized knowledge of how to make the products.



Home of Mr. J. W. Nelson. Stucco on concrete blocks. Rudol-  
Ave. and Chestnut Hill, Ruxburg, Baltimore, Md.  
J. W. Nelson, Builder

## Output

EVERY maker of concrete products is obviously interested in knowing how many blocks or bricks his machine will turn out.

The number of blocks he gets depends largely, in fact almost entirely, on two things: simplicity of design and reliability.



Cleveland Builders' Supply Co., Cleveland, Ohio

And because they are simple, sturdy, uncomplicated machines that are absolutely dependable, Anchor equipment will turn out more blocks or bricks in a year than you can get from any other machinery that you can put into your plant.

Because they are simple in design, breakdowns are few and far between. And when repairs are needed only one machine and one or two men are affected, not your whole plant.

That is another reason why these machines can go on, day after day and year after year, steadily piling up their production totals, with unbroken repetition, until they have outdistanced all other equipment.

They are simple. They need few adjustments. They are strong. They are sure. That is the story in a nutshell. Users of Anchor equipment know this. They know that they can depend on Anchor machines to exceed all others in profitable output.

Output depends on plant equipment and labor. For instance, if equipment is available to bring

material right up to the machines, and take away the blocks, he will turn out more than if he were carrying them some distance to and from the machine.

Often times estimates of production are based on ideal conditions. *Such promises of production do not work out in the shop.*

For that reason, Anchor equipment is not sold on the basis of a definite number of units of output per day or per year. Instead Anchor machines are sold on the basis of reliability which means that when conditions are equal, Anchor will turn out more units per dollar invested, and more units per man than any other equipment.

The Anchor Company points to letters signed by Anchor users. Anchor refers to the plants where its equipment is in use every day. Among these are numbered the most stable and profitable plants in the country.

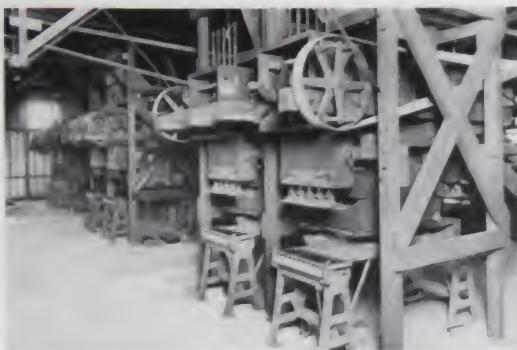
These plants show what Anchor has done in the past. They show how Anchor has performed. They tell the remarkable story of profitable production with Anchor equipment.



Cleveland Builders' Supply Co., Cleveland, Ohio

One of the biggest building supply companies in the country, has confidence in its concrete block department. It is paying well. More and more building supply dealers are going into the concrete products business each month. Besides the two strippers and Hobbs machines shown in this picture, two more strippers are now being installed. Each of the block machines and tampers shown in these pictures has been in continuous operation for more than eight years. Practically no upkeep expense

## The Anchor System



Interior View, Adamantex Brick Company  
Baltimore, Md.

EVERY day more concrete products plants join the procession of Anchor users. And one of the chief reasons is the *Anchor System*.

Every day both large and small plants are finding that the *Anchor System* is the road to profits.

*Buy Small Units—Add (not discard) as you grow;* that sums up the *Anchor System*. By means of the *Anchor System* a number of small independent units, simple practical machines each operated by one, or possibly two men, give you maximum production.

The *Anchor System* is best because of its:

1. *Small Investment*—Buy a single unit and add as you grow. Start with small capital. As your demand increases, install more units. All your money is thus always working.

2. *Flexible Output*—When demand is light, run few units. When demand is heavy, run as many as needed.

3. *Continuous Production*—Entire production never stopped on account of breakdown or adjustment. Only one unit affected, loss is small.

4. *Few Breakdowns*—Simple construction of strong Anchor units makes breakdowns and readjustments extremely rare.

5. *Variety of Products*—Makes rock, plain, panel and special blocks all at the same time, one kind on each machine. This means,

6. *Timesaving*—No need to be constantly changing parts. This saves wages; avoids trouble and delay; speeds up production; increases output.

7. *Satisfied Workmen*—Never necessary to lay several men off because one of crew is absent. Never need to take a man off his regular job while others of crew make adjustments.

These are the reasons why you find both big plants and smaller ones following the *Anchor System*.

These are the reasons why every day the procession of Anchor users grows in length. They are learning that *in the long run the Anchor System pays*.

Not long ago the Cemprod Engineering & Construction Company built, at Baltimore, Md., what was then the largest cement brick plant in the world. In this huge plant they installed the *Anchor System* entirely.

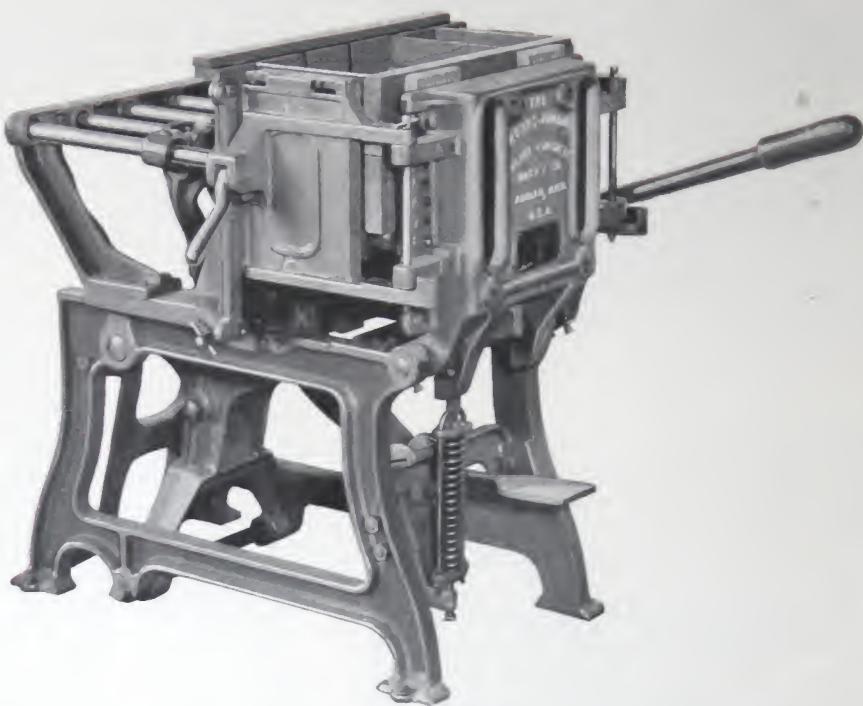
Since then they have built a still larger plant at Philadelphia, now the largest in the world, and again they chose the *Anchor System*.

This large firm has ample financial resources and made extensive investigation before they bought Anchor equipment. But like many others, they learned that the *Anchor System* of small independent units pays best *in the end*. If this is true in big plants, think what it means to the small plant!

*The Anchor System Insures More Blocks per Dollar Invested.*



A perfect pair of machines for small plant. A Hobbs for the faced and fractional blocks. A Stripper for the plain blocks.



## The Hobbs Machine

THE Hobbs block machine has become known throughout the world as the great general purpose machine. There are more Hobbs machines in operation today than any other type.

Added improvements in design of the Hobbs strengthen its claim to that already well-earned title.

The Hobbs is a quality face-down wet-process machine with a range of 2000 sizes. It makes the finest faced blocks, and yet makes common blocks with great speed.

The Hobbs is made in two sizes, the Senior and the Junior. All of the following information applies to both machines, except in the matter of block sizes. It must be remembered that the Hobbs Senior makes any size of block up to 12 by 12 by 24

inches and the Hobbs Junior any size up to 9 by 12 by 16 inches.

The Hobbs is either a veneer, a hollow block, or a two-piece wall machine, whichever you desire to turn it into.

To change it from a hollow block to a veneer block requires the longest of any change; this takes only five minutes.

Changing from a 4-inch to a 6-inch veneer takes only five moves of the bare hands.

Any regular length and any thickness in the wall from 3 to 12 inches is possible by these speedy and easy adjustments.

But what has aroused such wide spread comment about the Hobbs is its remarkable range for any height of block in the wall.

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## The Hobbs—Every Move Counts

*Every Move Counts*—That's the secret of the Hobbs speed. For instance you can make fractional blocks as quickly as whole ones, and on the same pallets. The automatic dividing plate is inserted and drawn with the cores; there are no hand inserted dividing plates.

The Hobbs also makes whole blocks faster than most other machines, because, unlike other machines, when making hollow blocks the cores are inserted after you put in the facing and before you start tamping.

No time is lost stopping the tamping to insert the cores.

Because the Hobbs is built true, you can make changes quicker than on any other machine.

*The Hobbs makes blocks quickly—makes changes quickly.*



*Hobbs, Sr., mold box open—Note the Senior Hobbs is constructed exactly the same as the Junior but that five full cores are used instead of three. The Senior will make blocks any size up to 12 by 12 by 24 inches*

Almost an endless variety of sizes and faces is possible with the Hobbs.

Its output—2000 distinct sizes of any one style such as rock, plain or panel-faced blocks—is nothing short of marvelous.

Think of it! Most block machines have a range of five to forty sizes, and the Hobbs has 2000. And remember every one of these 2000 sizes is made with the one back plate, one front standard and one frame that make up the regular Hobbs machine.

With the Hobbs, you are sure that with small cost for plates, you can make any size you will ever need.

You can make fractional sizes just as quickly as whole ones.

With the Hobbs you have available an extremely wide variety of face plate designs. Complete jamb, joist, bay window and other special block attachments can also be furnished.



## The Hobbs Is Built Right

THE Hobbs is designed properly and constructed with extreme care. It is built to last.

Every part is machined on costly and accurate jigs. That means that every part is true. All parts are interchangeable.

For this reason when you order a repair part, you are sure that it is going to fit. You know that you will not have any filing or fussing to make it fit.

Every adjustment is absolutely positive. No part can slip without shearing a pin or bolt.

It is impossible to set the machine in any way but the right way. It has no set screws. A pin or bolt must be put into an accurately drilled hole.

Every block must be absolutely true in all its dimensions. No other kind can be made on a Hobbs. The mold box will stay rigid and true no

matter how long or hard you use it, because it is constructed correctly.

Long and costly experiments have brought the Hobbs to its present simple perfected form. It is stout and strong; it weighs at least twice as much as any other machine in the same price class.

The frame is heavy and is graceful in design. The back plate is made exceptionally strong. The front standard and end doors are heavy enough to stand rough usage, but their weight is balanced by a special device so that virtually only the weight of the block is lifted.

It is impossible to make a wetter block than the Hobbs makes, because the oval cores form arches that prevent the concrete from sagging.

With the Hobbs cores you can make concrete just as wet as you could in making a solid block.

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## Description in Detail

### The Frame

THE frame of the Hobbs is constructed of the best gray iron properly braced to insure a rigid base for the machine, and is accurately finished to furnish a true surface on which the back plate is adapted to slide in adjusting.

### The Front Standard

The front standard to which the face plates and end doors are attached is hinged to the frame. It is provided with arms or lugs on which the end doors are hung. These arms are in turn provided with holes which allow the end doors to be adjusted lengthwise of the mold box to vary the length of the mold box from 16\* to 24 inches.

To illustrate: When it is desired on the Hobbs Senior to have a mold box 16 inches long each door is moved in four inches or as far as possible. To make a 20-inch mold box either door is moved in four inches, and to make an 18-inch mold box the other door is also moved in two inches. A 17, 19, 21, 22 or 23-inch mold box is made in like manner. The door jambs are also moved in to correspond.

This feature is original and saves you money, for it gives you many machines in one. Compare this positive adjustment with that of other machines.

The front standard is also provided with numbered holes by means of which the face plate is adjusted up or down to vary the depth of the mold box from 3 to 12 inches.

The face plate bar has steel pins that fit easily in these holes. To raise or lower the plate for different thickness of block and to drop in end plates to correspond takes but a moment.

This feature provides you with a machine that will make any style of block, either 3, 4, 5, 6, 7, 8, 9, 10, 11 or 12 inches in thickness or depth in the wall.

### The Back Plate

The back plate—the vital part of the machine—is a marvel of ingenuity. It has a long bearing surface in contact with the frame that is accurately machined which holds it square and rigid.

The face plate and end plates are clamped to the back plate, and insure an absolutely square block. The back plate is adjustable toward, or away from, the front standard to vary the width of the mold box. That is, after removing a steel pin from each side, it slides easily and quickly, on the finished frame to any desired position to accommodate a face plate for a block either 3, 4, 5, 6, 7, 8, 9, 10, 11 or 12 inches high when set in the wall.

The value of this adjustment is not fully appreciated until you operate the machine. You cannot make even one-half of these heights with any other machine. Anyone who can read can make this change, for each hole in the frame is numbered. To set up for say a 10-inch block, the back plate is moved so that the hole at the side registers over the hole in the frame marked 10 and the pin inserted.

The entire front surface and the top edge of the back plate are accurately machined. Ears with holes are placed on the top edge of the back plate. These furnish means for attaching any device that may ever be needed, such as a feed table, return corner, silo or circle attachments.

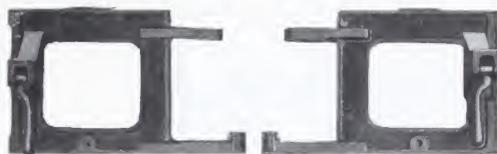
### Skeleton End Doors

The skeleton end doors are not only adjustable lengthwise of the mold box, but are provided with arms by means of which they are adjusted one inch in or out to accommodate a like adjustment of the back plate.

For instance, the 4-inch doors can be used with a 4 and a 3-inch width of mold box; the 8-inch doors can be used with an 8 and a 7-inch width of mold box, and the 12-inch doors can be used with a 12 and 11-inch width of mold box; 6 and 10-inch doors are also used in this manner.

The doors are provided with means for carrying the different depths of end plates for the different depths of the mold box.

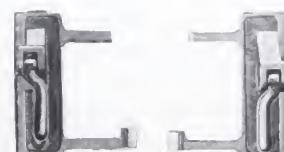
These doors have a latch which locks and squares all parts with the back plate. Bearing down on the handle of the latch locks the door, and raising releases it.



12" Skeleton Doors, Right and Left



8" Skeleton Doors, Right and Left



4" Skeleton Doors, Right and Left

\*An allowance of one-quarter inch is made for mortar joint on all blocks made on the Hobbs unless otherwise specified.

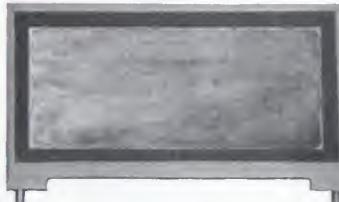
## Face Plates



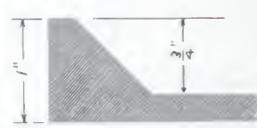
1. Plain and Panel Face Plate— $\frac{1}{4}$ -inch deep panel



2. Plain and Panel Face Plate— $\frac{1}{2}$ -inch deep panel



3. Plain and Panel Face Plate— $\frac{3}{4}$ -inch deep panel



4. Brick Face Plate



5. Rock Face Plate—No Margin



6. Rock Face Plate with  $\frac{1}{4}$ -inch plain Margin

### The above illustrations are standard types of Face Plates

Any other designs furnished to specifications

ALL of Hobbs plain face plates (not end plates), are reversible. That is, there is a face design on each side. All Hobbs plain face plates when reversed are a regular panel face plate for making a panel faced block. This clever expedient reduces the number of parts, the weight and the price. *Remember you get two plates for the price of one.*

Hobbs face plates approach perfection. They

are highly finished, absolutely accurate in all dimensions.

A wide variety of special and fancy face plates can be furnished to order. We make no attempt to show here the many types of cobblestone, brush-hammered, tooled, and other designs available.

Unless otherwise specified all machines will be equipped and repair orders filled with rock design No. 5 and panel No. 3.

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## The End Plates

UNLIKE other machines, the end plates in the Hobbs are provided with means by which they are inserted dovetail fashion into ways in the skeleton doors. No pins or set screws are used. To change the end plate you merely lift out of the skeleton door and insert another of the style and size desired. This takes but a few seconds.

This construction simplifies the machine and lessens the number of parts. Any even width of end plate in any depth from 3 to 12 inches will fit the same width of either right or left skeleton door. Owing to their peculiar design odd widths of end plates must be made in rights and lefts. See "Skeleton Doors."

All end plates make blocks that run full width, such as 8, 10 or 12 inches.

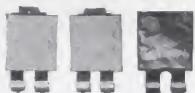
When it is so specified, special end plates can be furnished that, in making return corners, will make the block a quarter of an inch less than the regular thickness or width of the block.

To accomplish this the top of the end plate, when the machine is closed and ready to make a block, is a quarter of an inch below the top of the back plate. After the top of the mold box is struck off as usual the striker is held with the edge bearing on top of the return end plate and the surplus concrete removed with one stroke. This is necessary, of course, only with return corners. When making regular blocks all parts are flush or even with the top of the mold box.

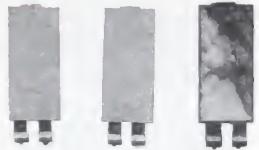
When using a rock return end plate at each end of the mold box for pier work a block is made just a quarter of an inch less in thickness than the regular block. For instance: An 8 by 8 by 16-inch block made in this manner for a pier would be exactly  $7\frac{3}{4}$  by  $7\frac{3}{4}$  by  $15\frac{3}{4}$  inches.

At a small extra cost, attachments can be furnished for raising

the face plate in the mold box one-quarter inch and thus all blocks will be one-quarter inch under the usual thickness. Then all end plates are flush with the top of the back plate at all times and every block will come right for pier work or corners. For instance, blocks which it is customary to make in even 4, 6, 8, 10 or 12 inches in thickness in the wall would be respectively  $3\frac{3}{4}$ ,  $5\frac{3}{4}$ ,  $7\frac{3}{4}$ ,  $9\frac{3}{4}$  and  $11\frac{3}{4}$  inches thick in the wall.



4 by 4" Plain and Rock End Plates



4 by 8" Plain and Rock End Plates



8 by 4" Plain and Rock End Plates



8 by 8" Panel, Plain and Rock End Plates



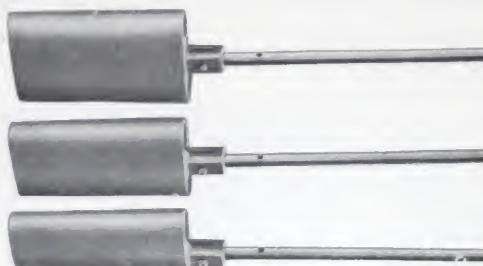
12 by 4" Plain and Rock End Plates



12 by 8" Plain and Rock End Plates

### Cores

THE cores are carried by the back plate and move with it when adjusting for various widths of the mold box. These cores are oval in shape to produce an arched opening which prevents a breaking down or sagging of a wet mixture, thus producing a stronger block than with air chambers of other shapes. From an engineering and practical standpoint this is the proper and only way to core out material in a concrete block.



A 12", 10" and 8" Core

With these small oval cores a mixture as wet as will stand up can be used. It is impossible to use a wetter concrete on any machine from which the block is removed as soon as made.

The cores are not rigid when in the mold box but have a slight play up and down. This characteristic permits the inserting of the cores after the facing is placed in the mold box and before the concrete is put in.

The cores being small and oval the first tamping forces the material under the cores and raises them a trifle—then the last tamping on top of the cores tamps them down solid and produces a very dense block all around the core openings.

This means that the tamping is not stopped to throw in the cores as with other machines and the result is that more blocks may be made in a day. This is an especially valuable feature when using a mechanical tamper. *Every More Counts.*

With these small cores you are able to core out the regular air space no matter what length of block, even if only four inches long. The cores are far enough apart to permit the use of gravel or stone the size of a small egg.

The cores are inserted into and removed from the mold box through openings in the back plate, by means of a hand and foot lever. There is a bar connecting the core rods to which the hand and foot levers are attached and by an arrangement on this bar the cores are starting one at a time. This is of great value in removing the cores from a wet mixture because it enables you to start them easily.

To accommodate the different sizes of cores that may be used with this machine, adjusting plates are provided that are carried by the back plate. These adjust the openings in the back plate for the different sizes of cores which vary in depth but not in width.

The standard Hobbs back plate accommodates cores which give 33 per cent air space in 8-inch wide blocks; 37 per cent air space in 10-inch blocks, and 38 per cent in 12-inch blocks. An oversize back plate can be furnished which accommodates 40 per cent cores in each width.

When making a solid or veneer block the cores are withdrawn and the core openings in the back plate are closed with plates provided for the purpose. Slotted cores are provided to be used with dividing plates when making fractional cored blocks.

### Dividing Plates

The dividing plates are made of steel and are a quarter of an inch thick which provides for the mortar joint in making fractional blocks. They are attached to the core shaft with a slotted core when dividing hollow blocks and are inserted and removed with the cores, positively without attention or lost time on the part of the operator.

Whenever the dividing plate is used sectional face plates are used. This construction allows the face plate to be adjusted up or down using the same dividing plate. The back plate is provided with slots in which the dividing plate is adapted to ride when moving in or out of the mold box. This allows the back plate to be adjusted in and out while the dividing plate is in position. *This construction permits the use of one size dividing plate for dividing all sizes of blocks.*

For instance, in dividing a 4-inch square block the upper front corner of the dividing plate is in the mold box and when dividing a 12-inch square block nearly the entire plate is in the mold box.

When using the dividing plate for solid or veneer blocks the core is removed and the dividing plate only is left on the core shaft. It is then inserted through the mold box until it comes against the pallet and is left stationary. The blocks are lifted away from the dividing plate and thus fractional solid blocks are made without one extra move.



16" Junior Slotted Core with dividing plate

## Sectional Face Plates

ONE of the original and most valuable features of the Hobbs is the use of sectional face plates for making fractional blocks.

In making all blocks, the face plate or plates are attached by means of steel pins to a steel bar that is accurately drilled with a series of holes to receive these pins. These holes are so laid out that no matter in what position two or more face plates are attached to the bar they are one-quarter inch apart and the slot so formed when the machine is closed lines up exactly with a quarter-inch slot in the back plate.

These slots in the back plate occur every four inches and are in the center of the core openings. Therefore, if you attach a steel dividing plate that is one-quarter inch thick to a core shaft with a slotted core, in making hollow blocks, this combination core and dividing plate can be inserted and removed with the rest of the cores without attention or loss of time by the operator.

The dividing plate rides in the slot in the back plate and is guided and held by the slot between the fractional plates, no matter whether the sectional plates are in the bottom of the mold box for making blocks 12 inches thick, or whether they are near the top for making 4-inch veneer.

Therefore only *one size of dividing plate* is needed for operating the Hobbs to make any of the 2000 sizes that it is adapted for. And, more interesting still, is the fact that the dividing plate, no matter in what position, is always even or flush with the top of the back plate. *This gives a free strike off and makes the Hobbs the fastest machine on the market for making fractional and special sizes.*

This is why *real Broken Ashlar* can be made as cheaply as common work. A study of the Hobbs will convince you that this is reasonable.

If the Hobbs were no better than other machines in all other respects this feature alone would make it the *best*.

By this construction the Hobbs also saves you money when you require extra plates. For instance, if you required an 8-inch width of face plate 6 inches long, in addition to the Hobbs regular equipment you would need to

buy only an 8 by 6-inch plate at a small part of the cost of an 8 by 24-inch fractional plate dividing by a groove into a 6 and 18-inch section. With the Hobbs this 6-inch plate can be attached to the bar with a 16 or a 12 and a 4-inch length which are all regular plates.

Five dividing plates are needed if you want to make bricks or a large number of very small size blocks, but otherwise only one or two dividing plates are required for every size. Other machines possessing only one-tenth of the range of the sizes the Hobbs has, require ten times the number of dividing plates.

The following sizes of face plates are standard. Face plates of any size will be made to specification.

Size	Size	Size
12 x 24"	10 x 8"	6 x 14"
12 x 22"	10 x 6"	6 x 12"
12 x 20"	10 x 4"	6 x 10"
12 x 18"	8 x 24"	6 x 8"
12 x 16"	8 x 22"	6 x 6"
12 x 14"	8 x 20"	6 x 4"
12 x 12"	8 x 18"	4 x 24"
12 x 10"	8 x 16"	4 x 22"
12 x 8"	8 x 14"	4 x 20"
12 x 6"	8 x 12"	4 x 18"
12 x 4"	8 x 10"	4 x 16"
10 x 24"	8 x 8"	4 x 14"
10 x 22"	8 x 6"	4 x 12"
10 x 20"	8 x 4"	4 x 10"
10 x 18"	6 x 24"	4 x 8"
10 x 16"	6 x 22"	4 x 6"
10 x 14"	6 x 20"	4 x 4"
10 x 12"	6 x 18"	
10 x 10"	6 x 16"	

Wherever face plates or end plates are mentioned in this handbook the first figures mentioned determine the height of the block in the wall. For instance, a 12 by 4-inch face plate is for a block that sets 12 inches high in the wall and is four inches long. A 4 by 8-inch end plate is for making an 8-inch return on a block 4 inches high in the wall.

## Pallets

IRON or wood pallets up to  $1\frac{7}{8}$  inches thick can be used on the Hobbs. By special arrangement this machine can be equipped to use any standard make of iron pallet.



## The Broken Ashlar Outfit

### Hobbs Senior Outfit No. 1

THIS equipment is adapted to the needs of the block manufacturer who wants to do good work. Leave out one single plate and you may need it within a week. With it you can make 36 distinct sizes of rock faced blocks either with plain or

#### 1—MODEL "A" MACHINE

- 5—Full 8" Cores
- 1—Half 8" Core, Right Hand
- 1—Half 8" Core, Left Hand
- 2—Slotted 8" Full Cores
- 2—Dividing Plates
- 5—Core Adjusting Plates
- 2—Core Adjusting Plates, Slotted
- 1—Half Core Adjusting Plate, Right Hand
- 1—Half Core Adjusting Plate, Left Hand
- 5—Full Core Opening Filler Plates
- 2—Full Core Opening Filler Plates, Slotted
- 1—Half Core Opening Filler Plate, Right Hand
- 1—Half Core Opening Filler Plate, Left Hand
- 2—Wrenches, 1 Whisk Broom, 1 Sample Pallet, 1 Striker
- 1—Hand Tamper
- 2—Long Face Plate Supporters
- 1—Short Face Plate Supporter
- 1—16" Face Plate Bar
- 1—24" Face Plate Bar
- 1—4" Skeleton Right End Door
- 1—4" Skeleton Left End Door
- 1—8" Skeleton Right End Door
- 1—8" Skeleton Left End Door
- 1—12" Skeleton Right End Door
- 1—12" Skeleton Left End Door
- 1—12 x 24" Rock Face Plate
- 1—12 x 20" Rock Face Plate
- 1—12 x 16" Rock Face Plate
- 1—12 x 12" Rock Face Plate
- 1—12 x 8" Rock Face Plate
- 1—12 x 4" Rock Face Plate

Shipping weight—1400 pounds.

Displacement—43.5 cubic feet.

Unless otherwise specified cores giving 33 per cent air space are furnished. Cores giving 40 per cent air space can be furnished if so desired.

Code Used—Western Union

Code word for this outfit with 33 per cent cores—"Laxos."

Code word for this outfit with 40 per cent cores—"Fackel."

rock faced return and the 8-inch high stone with a panel faced return. You can make 10 distinct sizes of plain face blocks and 10 of panel face blocks. You can also make bay window blocks.

- 1—8 x 24" Rock Face Plate
- 1—8 x 20" Rock Face Plate
- 1—8 x 16" Rock Face Plate
- 1—8 x 12" Rock Face Plate
- 1—8 x 8" Rock Face Plate
- 1—8 x 4" Rock Face Plate
- 1—4 x 24" Rock Face Plate
- 1—4 x 20" Rock Face Plate
- 1—4 x 16" Rock Face Plate
- 1—4 x 12" Rock Face Plate
- 1—4 x 8" Rock Face Plate
- 1—4 x 4" Rock Face Plate
- 1—12 x 8" Rock Face End Plate
- 1—12 x 4" Rock Face End Plate
- 1—8 x 8" Rock Face End Plate
- 1—8 x 4" Rock Face End Plate
- 1—4 x 8" Rock Face End Plate
- 2—12 x 8" Plain End Plates
- 2—12 x 4" Plain End Plates
- 2—8 x 8" Plain End Plates
- 2—8 x 4" Plain End Plates
- 2—4 x 8" Plain End Plates
- 2—4 x 4" Plain End Plates
- 1—8 x 24" Plain and Panel Face Plate
- 1—8 x 16" Plain and Panel Face Plate
- 1—8 x 12" Plain and Panel Face Plate
- 1—8 x 8" Plain and Panel Face Plate
- 1—8 x 4" Plain and Panel Face Plate
- 1—8 x 8" Panel End Plate
- 1—8" Bay Window Attachment

This range of styles and sizes enables you to avoid monotony in your work. Apart from Real Broken Ashlar, which may be made with this equipment, no two jobs need look alike. You can run alternate courses of different heights or styles of blocks. You can use 12-inch high blocks in heavy foundations and large structures and gain a tone and character impossible with small blocks. This means that you can approach and even surpass the best stone work for constructing large buildings.

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## Hobbs Senior Outfit No. 2

HOBBS Senior 24-inch machine to make 8 by 8 by 24-inch blocks in rock, plain and panel face in full lengths, fractionals, and corner blocks as follows:

1—24" HOBBS SENIOR BLOCK MACHINE  
 5—Full 8" Cores  
 1—Half 8" Core, Right Hand  
 1—Half 8" Core, Left Hand  
 2—Slotted 8" Full Cores  
 2—Dividing Plates  
 5—Core Adjusting Plates  
 2—Core Adjusting Plates, Slotted  
 1—Half Core Adjusting Plate, Right Hand  
 1—Half Core Adjusting Plate, Left Hand  
 5—Full Core Opening Filler Plates  
 2—Full Core Opening Filler Plates, Slotted  
 1—Half Core Opening Filler Plate, Right  
 1—Half Core Opening Filler Plate, Left  
 1—Striker, 2 Wrenches  
 1—Sample Pallet, 1 Whisk Broom  
 1—Hand Tamper  
 2—Long Face Plate Supporters  
 1—16" Face Plate Bar  
 1—24" Face Plate Bar

1—8" Skeleton Right End Door  
 1—8" Skeleton Left End Door

### EQUIPMENT

1—8 x 24" Rock Face Plate  
 1—8 x 20" Rock Face Plate  
 1—8 x 16" Rock Face Plate  
 1—8 x 12" Rock Face Plate  
 1—8 x 8" Rock Face Plate  
 1—8 x 4" Rock Face Plate  
 1—8 x 8" Rock Face End Plate  
 2—8 x 8" Plain End Plates  
 1—8 x 8" Panel End Plate  
 1—8 x 24" Plain and Panel Face Plate  
 1—8 x 20" Plain and Panel Face Plate  
 1—8 x 16" Plain and Panel Face Plate  
 1—8 x 12" Plain and Panel Face Plate  
 1—8 x 8" Plain and Panel Face Plate  
 1—8 x 4" Plain and Panel Face Plate

### PRICES QUOTED UPON APPLICATION

### This Outfit Makes These Sizes

#### BLOCKS IN ROCK, PLAIN AND PANEL FACES AND ENDS

8 x 8 x 24"	8 x 8 x 12"
8 x 8 x 20"	8 x 8 x 8"
8 x 8 x 16"	8 x 8 x 4"

Standard cores give 33 per cent air space, 40 per cent cores furnished when specified. This is a very popular outfit. Additional equipment to make other sizes on this machine may be purchased at any time.

Shipping weight—1050 pounds.

Displacement—36 cubic feet.

Code Used—Western Union

Code word for this outfit with 33 per cent cores—"Eductor."

Code word for this outfit with 40 per cent cores—"Destine."

*Wherever face plates or end plates are mentioned in this handbook the first figures mentioned determine the height of the block in the wall. For instance, a 12 by 4-inch face plate is for a block that sets 12 inches high in the wall and is 4 inches long. A 4 by 8-inch end plate is for making an 8-inch return on a block 4 inches high in the wall.*

## Hobbs Senior Outfit No. 3

HOBBS Senior 24-inch machine to make 8 by 10 by 24-inch blocks in rock, plain and panel face in full lengths, fractionals, and corner blocks. This outfit includes the same parts and equipment as outfit No. 2 except they are for making blocks 10 inches wide.

### This Outfit Makes These Sizes

#### BLOCKS IN ROCK, PLAIN AND PANEL FACES AND ENDS

8 x 10 x 24"	8 x 10 x 12"
8 x 10 x 18"	8 x 10 x 8"
8 x 10 x 16"	8 x 10 x 4"

#### PRICES QUOTED UPON APPLICATION

Standard cores give 37 per cent air space. 40 per cent cores furnished when specified.

Wood or iron pallets can be used on all Hobbs machines. Any other make of pallets, either wood or iron, can be used by furnishing sample.

Shipping weight—1250 pounds.

Displacement—39.5 cubic feet.

Code Used—Western Union

Code word for this outfit with 37 per cent cores—"Galoch."

Code word for this outfit with 40 per cent cores—"Spoor."

## Hobbs Senior Outfit No. 4

HOBBS Senior 24-inch machine to make 8 by 12 by 24-inch blocks in rock, plain and panel face in full lengths, fractionals, and corner blocks. This outfit includes the same parts and equipment as outfit No. 2 except they are for making blocks 12 inches wide.

### This Outfit Makes These Sizes

#### BLOCKS IN ROCK, PLAIN AND PANEL FACES AND ENDS

8 x 12 x 24"	8 x 12 x 8"
8 x 12 x 16"	8 x 12 x 4"
8 x 12 x 12"	

#### PRICES QUOTED ON APPLICATION

Standard cores give 38 per cent air space. 40 per cent cores furnished when specified.

Quality always pays. The Hobbs is built a little better than seems necessary.

Shipping weight—1275 pounds. Displacement—44 cubic feet.

Code word for this outfit with 38% cores—"Gamely."

Code word for this outfit with 40% cores—"Edifice."

## Hobbs Junior Outfit No. 10

HOBBS Junior, 16-inch machine to make 8 by 8 by 16-inch blocks in the rock, plain, and panel face in full lengths, fractionals and corner blocks as follows:

1—16" HOBBS JUNIOR BLOCK MACHINE  
 3—Full 8" Cores  
 1—Half 8" Core, Right Hand  
 1—Half 8" Core, Left Hand  
 1—Slotted 8" Full Core  
 1—Dividing Plate  
 3—Core Adjusting Plates  
 1—Core Adjusting Plate, Slotted  
 1—Half Core Adjusting Plate, Right Hand  
 1—Half Core Adjusting Plate, Left Hand  
 3—Full Core Opening Filler Plates  
 1—Full Core Opening Filler Plate, Slotted  
 1—Half Core Opening Filler Plate, Right  
 1—Half Core Opening Filler Plate, Left  
 1—Striker, 1 Wrench  
 1—Sample Pallet, 1 Whisk Broom  
 1—Hand Tamper

1—Long Face Plate Supporter  
 1—16" Face Plate Bar  
 1—8" Skeleton Right End Door  
 1—8" Skeleton Left End Door

EQUIPMENT  
 1—8 x 16" Rock Face Plate  
 1—8 x 12" Rock Face Plate  
 2—8 x 8" Rock Face Plates  
 1—8 x 4" Rock Face Plate  
 1—8 x 8" Rock Face End Plate  
 2—8 x 8" Plain End Plates  
 1—8 x 8" Panel End Plate  
 1—8 x 16" Plain and Panel Face Plate  
 1—8 x 12" Plain and Panel Face Plate  
 2—8 x 8" Plain and Panel Face Plates  
 1—8 x 4" Plain and Panel Face Plate

### This Outfit Makes the Following Sizes

#### BLOCKS IN ROCK, PLAIN AND PANEL FACES AND ENDS

8 x 8 x 16"	8 x 8 x 8"
8 x 8 x 12"	8 x 8 x 4"

#### PRICES QUOTED UPON APPLICATION

Standard cores give 33 per cent air space. 40 per cent cores furnished when specified.

*This is the most popular block making outfit in use today.*

For extra equipment see pages 23 and 24.

Shipping weight—742 pounds.  
 Displacement—23 cubic feet.

Code Used—Western Union  
 Code word for this outfit with 33 per cent cores—"Lastro."  
 Code word for this outfit with 40 per cent cores—"Legal."

## Hobbs Junior Outfit No. 11

HOBBS Junior 16-inch machine to make 8 by 10 by 16-inch blocks in the rock, plain, and panel face in full lengths, fractionals, and corner blocks. This outfit includes the same parts and equipment as outfit No. 10 except they are for making blocks 10 inches wide.

### This Outfit Makes the Following Sizes

#### BLOCKS IN ROCK, PLAIN AND PANEL FACES AND ENDS

8 x 10 x 16"	8 x 10 x 8"
8 x 10 x 12"	8 x 10 x 4"

#### PRICES QUOTED UPON APPLICATION

Standard cores give 37 per cent air space. 40 per cent cores furnished when specified.

*Quality always pays. The Hobbs is built a little better than seems necessary.*

For extra equipment see pages 23 and 24.

Shipping weight—880 pounds.

Displacement—25 cubic feet.

Code Used—Western Union

Code word for this outfit with 37 per cent cores—"Becas."

Code word for this outfit with 40 per cent cores—"Polon."

## Hobbs Junior Outfit No. 12

HOBBS Junior 16-inch machine to make 8 by 12 by 16-inch blocks in the rock, plain, and panel face in full lengths, fractionals, and corner blocks. This outfit includes the same parts and equipment as outfit No. 10 except they are for making blocks 12 inches wide.

### This Outfit Makes the Following Sizes

#### BLOCKS IN ROCK, PLAIN AND PANEL FACES AND ENDS

8 x 12 x 16"	8 x 12 x 8"
8 x 12 x 12"	8 x 12 x 4"

#### PRICES QUOTED UPON APPLICATION

Standard cores give 38 per cent air space. 40 per cent cores furnished when specified.

Wood or iron pallets can be used on any Hobbs machine. Any other make of pallets, either wood or iron, can be used by furnishing sample.

For extra equipment see pages 23 and 24.

Shipping weight—890 lbs.

Displacement—25 cubic feet.

Code Used—Western Union

Code word for this outfit with 38 per cent cores—"Ebony."

Code word for this outfit with 40 per cent cores—"Crusty."

## Extra Hobbs Equipment

ADDITIONAL equipment necessary for making the following thicknesses of wall blocks on the Hobbs Senior or Junior machine when one machine has already been installed.

Always specify the size of machine you already have.

### 4" THICKNESS OF WALL

- 2—8 x 4" Plain End Plates
- 1—8 x 4" Rock Face End Plate
- 1—8 x 4" Panel End Plate

### 6" THICKNESS OF WALL

- 2—8 x 6" Plain End Plates
- 1—8 x 6" Rock Face End Plate
- 1—8 x 6" Panel End Plate
- 1—Set of 6" Cores Complete

### 8" THICKNESS OF WALL

- 2—8 x 8" Plain End Plates
- 1—8 x 8" Rock Face End Plate

### 10" THICKNESS OF WALL

- 1—Set of 8" Cores Complete
- 2—8 x 10" Plain End Plates
- 1—8 x 10" Rock Face End Plate
- 1—8 x 10" Panel End Plate
- 1—Set of 10" Cores Complete

### 12" THICKNESS OF WALL

- 2—8 x 12" Plain End Plates
- 1—8 x 12" Rock Face End Plate
- 1—8 x 12" Panel End Plate
- 1—Set of 12" Cores Complete

### PRICES QUOTED UPON APPLICATION

ADDITIONAL equipment necessary for making the following heights of blocks on the Hobbs Senior or Junior machine when one machine has already been installed.

Parts marked \* are not required if equipment is for the Junior machine.

### 4" HIGH BLOCKS

- 2—4 x 8" Plain End Plates
- 1—4 x 8" Rock Face End Plate
- 1—4 x 8" Panel End Plate
- 1—4" Right Skeleton Door
- 1—4" Left Skeleton Door
- \*1—4 x 24" Rock Face Plate
- \*1—4 x 20" Rock Face Plate
- 1—4 x 16" Rock Face Plate
- 1—4 x 12" Rock Face Plate
- 1—4 x 8" Rock Face Plate
- 1—4 x 4" Rock Face Plate
- \*1—4 x 24" Plain and Panel Face Plate
- \*1—4 x 20" Plain and Panel Face Plate
- 1—4 x 16" Plain and Panel Face Plate
- 1—4 x 12" Plain and Panel Face Plate
- 1—4 x 8" Plain and Panel Face Plate
- 1—4 x 4" Plain and Panel Face Plate

### 1—6 x 12" Rock Face Plate

- 1—6 x 8" Rock Face Plate
- 1—6 x 4" Rock Face Plate
- \*1—6 x 24" Plain and Panel Face Plate
- \*1—6 x 20" Plain and Panel Face Plate
- 1—6 x 16" Plain and Panel Face Plate
- 1—6 x 12" Plain and Panel Face Plate
- 1—6 x 8" Plain and Panel Face Plate
- 1—6 x 4" Plain and Panel Face Plate

### 8" HIGH BLOCKS

- 2—8 x 8" Plain End Plates
- 1—8 x 8" Rock Face End Plate
- 1—8 x 8" Panel End Plate
- 1—8" Right Skeleton Door
- 1—8" Left Skeleton Door
- \*1—8 x 24" Rock Face Plate
- \*1—8 x 20" Rock Face Plate
- 1—8 x 16" Rock Face Plate
- 1—8 x 12" Rock Face Plate
- 1—8 x 8" Rock Face Plate
- 1—8 x 4" Rock Face Plate
- \*1—8 x 24" Plain and Panel Face Plate
- \*1—8 x 20" Plain and Panel Face Plate
- 1—8 x 16" Plain and Panel Face Plate
- 1—8 x 12" Plain and Panel Face Plate
- 1—8 x 8" Plain and Panel Face Plate
- 1—8 x 4" Plain and Panel Face Plate

### 6" HIGH BLOCKS

- 2—6 x 8" Plain End Plates
- 1—6 x 8" Rock Face End Plate
- 1—6 x 8" Panel End Plate
- 1—6" Right Skeleton Door
- 1—6" Left Skeleton Door
- \*1—6 x 24" Rock Face Plate
- \*1—6 x 20" Rock Face Plate
- 1—6 x 16" Rock Face Plate

## Extra Hobbs Equipment—Continued

## 9" HIGH BLOCKS

2—9 x 8" Plain End Plates
1—9 x 8" Rock Face End Plate
1—9 x 8" Panel End Plate
1—9" Right Skeleton Door
1—9" Left Skeleton Door
*1—9 x 24" Rock Face Plate
*1—9 x 20" Rock Face Plate
1—9 x 16" Rock Face Plate
1—9 x 12" Rock Face Plate
2—9 x 8" Rock Face Plates
1—9 x 4" Rock Face Plate
*1—9 x 24" Plain and Panel Face Plate
*1—9 x 20" Plain and Panel Face Plate
1—9 x 16" Plain and Panel Face Plate
1—9 x 12" Plain and Panel Face Plate
1—9 x 8" Plain and Panel Face Plate
1—9 x 4" Plain and Panel Face Plate

## 12" HIGH BLOCKS

For use with the Senior Machines only

2—12 x 8" Plain End Plates
1—12 x 8" Rock Face End Plate
1—12 x 8" Panel End Plate
1—12" Right Skeleton Door
1—12" Left Skeleton Door
1—12 x 24" Rock Face Plate
1—12 x 20" Rock Face Plate
1—12 x 16" Rock Face Plate
1—12 x 12" Rock Face Plate
1—12 x 8" Rock Face Plate
1—12 x 4" Rock Face Plate
1—12 x 24" Plain and Panel Face Plate
1—12 x 20" Plain and Panel Face Plate
1—12 x 16" Plain and Panel Face Plate
1—12 x 12" Plain and Panel Face Plate
1—12 x 8" Plain and Panel Face Plate
1—12 x 4" Plain and Panel Face Plate

## SKELETON DOORS

Same door fits either the Senior or Junior Machine	
4" Right Hand	8" Left Hand
4" Left Hand	9" Right Hand
6" Right Hand	9" Left Hand
6" Left Hand	*12" Right Hand
8" Right Hand	*12" Left Hand

For Sr.  
Mach. only

## CORES

## 1—Set of 6" Cores Complete

16-inch Set-up for		
Sr.	Jr.	Sr.
3	3	5
1	1	2
1	1	1
1	1	1
3	3	5
1	1	2
1	1	1
1	1	1
1	1	1
1	1	1

## 1—Set of 8" Cores Complete

16-inch Set-up for		
Sr.	Jr.	Sr.
3	3	5
1	1	2
1	1	1
1	1	1

## 1—Set of 10" Cores Complete

16-inch Set-up for		
Sr.	Jr.	Sr.
3	3	5
1	1	2
1	1	1
1	1	1
1	1	1
1	1	1

## 1—Set of 12" Cores Complete

16-inch Set-up for		
Sr.	Jr.	Sr.
3	3	5
1	1	2
1	1	1
1	1	1
1	1	1
1	1	1

In ordering repair parts always state whether they are for the Senior or Junior machine

## PRICES QUOTED UPON APPLICATION

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## Special Hobbs Attachments



Hobbs, Jr. equipped with Bay Window attachment

THE Hobbs machine has been so designed that attachments for special sizes and shapes can be put on easily and operated quickly.

The most important of these is the Octagon or Bay Window Block attachment. This attachment positively never fails to work. To use it remove either the right or left end plate and attach the bay window device instead.

A separate attachment only is required for different width of mold box for different heights of blocks. It can be raised or lowered to make octagon blocks in any thickness from 4 to 12 inches. It can be set at any angle from 20 to 75 degrees. It is used in combination with any regular face plate under 20 inches in length. Only a face plate for the 4-inch return is required.

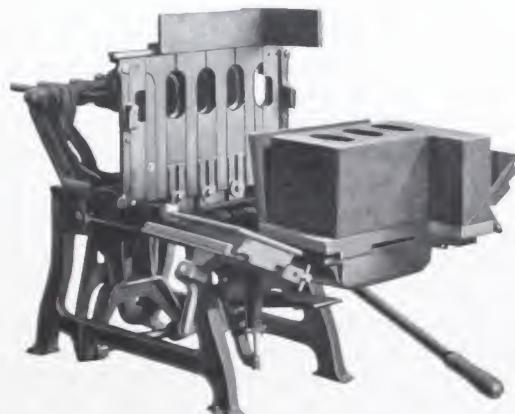
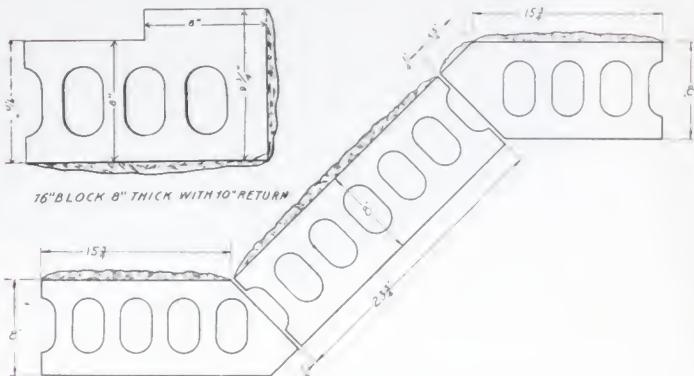
Almost the regular amount of air space can be had. Regular pallets are used and the dividing plate can be used for making all lengths of bay window blocks from 4 to 20 inches. *It is absolutely positive in all its adjustments.*

*The Hobbs Return Corner Attachment* for making a longer or shorter return than the thickness of the

block consists of a device for bolting on top of the back plate which in combination with a special end plate forms the return. It operates easily and quickly and can be furnished in all sizes.

Circle or Silo Face and End Plates are furnished to order for any radius.

The Anchor engineering department and the Anchor pattern and machine shop are prepared to make all kinds of special plates and attachments to your order.



Hobbs, Jr. equipped with four-inch Return Corner attachment

## The Hobbs Makes Almost Every Size and Face Real Broken Ashlar



*Real Broken Ashlar wall, see diagram on opposite page*

THE marvelous range of sizes and faces possible on the Hobbs makes it especially suited to making real Broken or Random Ashlar.

It is generally laid up in rock-faced blocks, but it can be used in tooled, plain or hammered face. The Hobbs was designed and equipped particularly for this work.

You cannot imagine how much broken ashlar in concrete blocks made with Hobbs plates looks like real stone. You simply have to see it.

By using 18 different sizes (or less) of blocks and by reversing some of these, you will not notice two blocks in the wall that look alike, unless you search for them.

This eliminates the monotonous appearance of rock-faced block as made on other machines.

Imitation ashlar block with false joints are too artificial to have a pleasing appearance.

Hobbs regular equipment is adapted for making real broken ashlar for a 4-inch unit system. Blocks

that lay 4, 8, and 12 inches high in the wall and each height in blocks 4, 8, 12, 16, 20 and 24 inches in length are used. With Hobbs regular equipment each one of these 18 sizes can be made in 4-inch thick veneer or in 18-inch blocks with about one-third air space. Each block can also be made with a 4 or an 8-inch rock or plain faced return corner.

Plates for making blocks 3, 6, 9 and 12 inches high for a 3-inch unit system of broken ashlar can also be furnished.

In California this broken ashlar work is usually made in 4-inch veneer and backed up with cheap bricks or blocks. One or two of the smaller sized blocks can be made 8 inches in depth or thickness and used as a header to bind the outer to the inner wall. Or it can be laid in a two-piece wall and tied with metal ties or made in solid or cored blocks for any thickness of wall. End plates for making other thicknesses are inexpensive.

# The Hobbs Makes Quality Blocks

As FRACTIONAL blocks are made on the Hobbs at positively no increase in time or trouble by means of the automatic dividing plates, it costs no more to produce real broken ashlar than it does the same number of cubic feet of 8-inch high standard size blocks on the Hobbs or other machines.

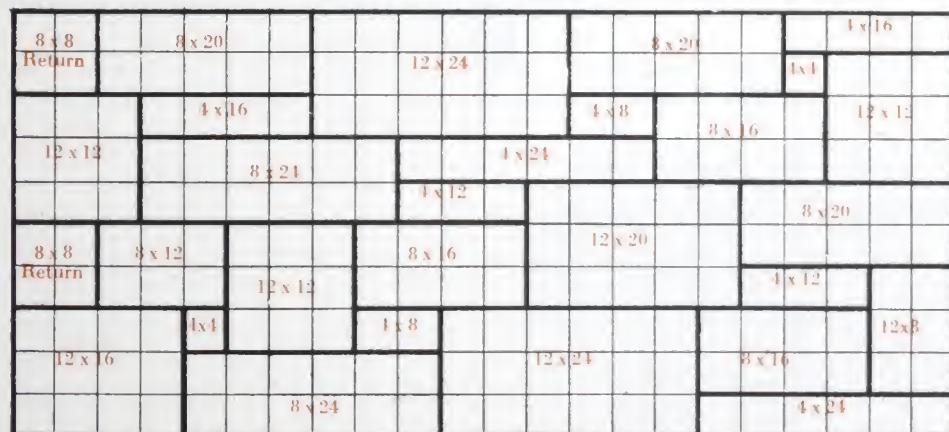
The time that is lost in making the 4-inch high blocks is gained in making the 12-inch and the average time is the same as for making blocks 8 inches high. The only extra cost is for setting the work.

Stone masons that are familiar with laying broken ashlar in stone work as a rule need no instructions. Others learn easily and like the work, for it is very interesting. If you will devote an hour or two to each job and detail the work so that the number required and the position of each size stone is determined, then any one who can set any kind of block can lay broken ashlar. By getting out rough detailed plans you know exactly how many of each size block is required for the job. This list of sizes can then be given to your yard man and the exact number of blocks deliv-

ered on the job. The mason then sets the blocks according to the rough drawing. By this method you can figure to a cent what a job will cost; there is no guesswork.

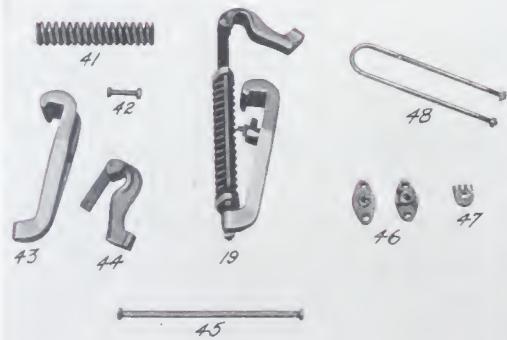
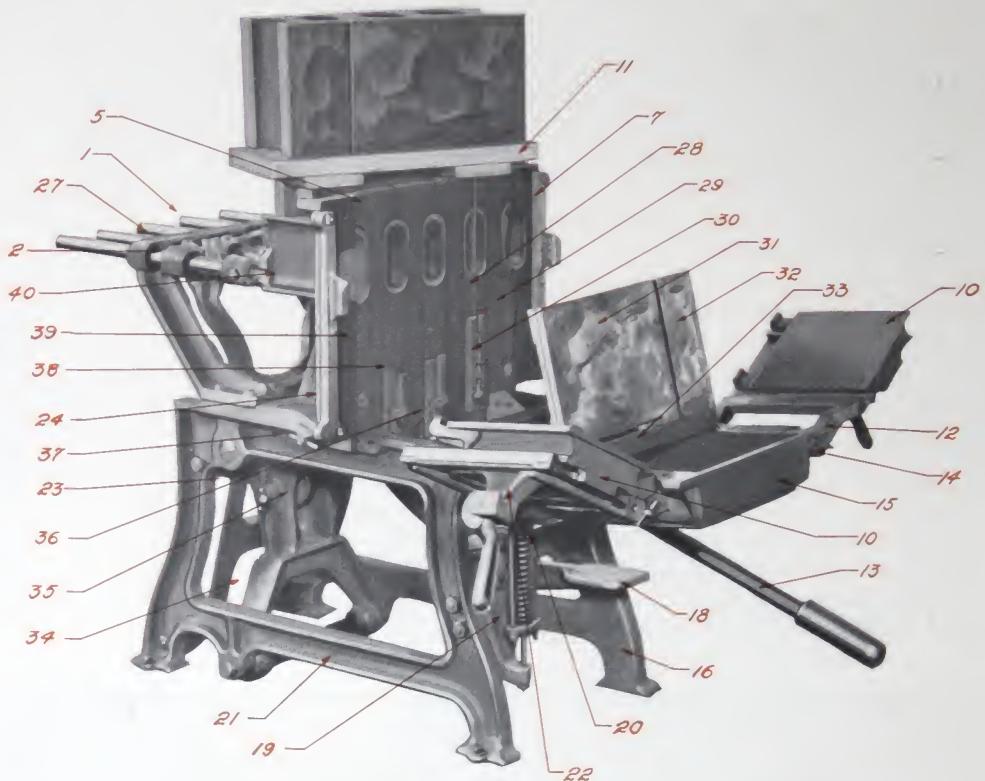
Real broken ashlar requires at least three different heights and various lengths of block that will bond together properly.

Anchor regular equipment makes blocks in lengths up to 24 inches and in three heights—4, 8 and 12 inches. Extra plates can be furnished for making ashlar in blocks 3, 6 and 9 inches high, and also 3, 6, 9 and 12 inches high and in any face desired. The 4, 8 and 12 ashlar is the best for block work. You simply lay it "two against one," that is, you set two 4-inch high blocks against an eight and a four and an eight against a twelve. The vertical joints will thus never be more than two blocks high. The horizontal or bed joint should never be longer than the length of four or five blocks. Two or three blocks should never be laid against two nor one against one except at openings or at the start or finish of a wall. This is simple, and is quickly learned by anyone.



This diagram shows method of detailing broken ashlar. It is optional whether this work is detailed as shown or whether it is left for the mason to set as he chooses. Scale: 1-16. Each square equals sixteen square inches.

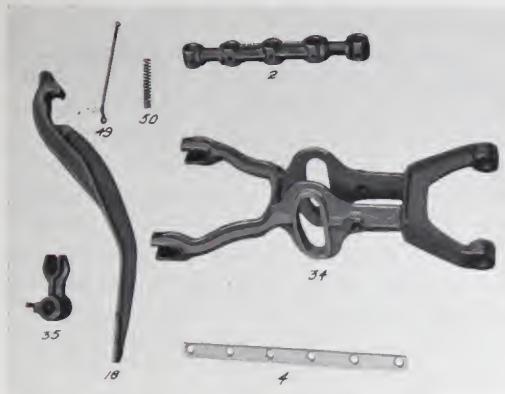
## Repair Parts Guide for Hobbs Machines



In ordering repair parts *always* give the serial number of your machine as found on the brass name plate. State whether your machine is Senior or Junior. If the part you require is not listed here, send the Anchor Company a rough sketch and description of the part required.

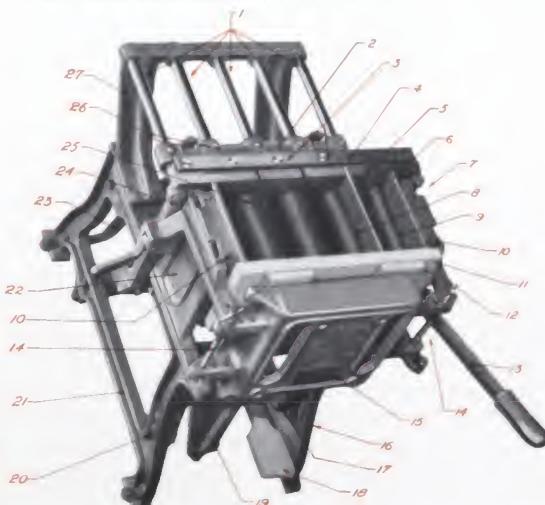
Part Number
1 C
2 C
3 T
4 B
5 B
6 D
7 R
8 8'
9 8"
10 8
11 8
12 8"
13 H
14 D
15 F
16 R
17 L
18 F
19 B
20 F
21 L
22 8
23 R
24 L
25 8"
26 C
27 C
28 S
29 R
30 R

## Repair Parts Guide for Hobbs Machines—Continued



Part Number	Name of Part	Pattern Number Hobbs Junior	Pattern Number Hobbs Senior
1	Core Rods		
2	Core Draft Bar	B8	A8
3	Tie Bar Screws		
4	Back Plate Tie Bars		
5	Back Plate	B7	A7
6	Dividing Plate		
7	Right Hand Door Jamb	A15	A15
8	8" Jr. Slotted Core	B20 1/2	A22
9	8" R. H. Jr. Half Core	B22	A22
10	8 x 8 Plain End Plate	AL4	AL4
11	8 x 16 Wood Pallet		
12	8" R. H. Skeleton Door	A48	A48
13	Hand Lever	A54	A54
14	Door Hinge Pin	A41	A41
15	Front Standard	B10	A10
16	R. H. Leg or Frame	B1	A1
17	Lever and Link		
18	Foot Lever	B3 1/2	A3 1/2
19	Bal. Device Complete		
20	Front Cross Member	B6	A6
21	L. H. Leg or Frame	B2	A2
22	8" L. H. Skeleton Door	A49	A49
23	Rear Cross Member	B5	A5
24	L. H. Door Jamb	A16	A16
25	8" Jr. Full Core	B20	A20
26	Core Rod Pins	A40	A40
27	Core Rod Support and Guide	B9	A9
28	Slotted Core Adjusting Plate	A29 1/2	A29 1/2
29	R. H. Half Core Adjusting Plate	A26	A26
	R. H. Half Core Filler Plate	A27	
	used here in making slabs		

Part Number	Name of Part	Pattern Number Hobbs Junior	Pattern Number Hobbs Senior
30	Short Face Plate Support		
31	8 x 12 Rock Face Plate		
32	8 x 4 Rock Face Plate		
33	16" Face Plate Bar		
34	Yoke	B3	A3
35	Hand Lever Fork	B4	A4 1/2
36	Corrugated Washer	A118 1/2	A118 1/2
	1/2 x 1 1/4" Cap Screw		
37	Back Plate Pin	A39	A39
38	Filler Core Adjusting Plate	A29	A29
	Filler Core Filler Plate		
	used here in slabs		
39	L. H. Half Core Adj. Plate	A25	A25
	L. H. Half Core Filler Plate	A28	A28
	used here in slabs		
40	L. H. Half Core	B24	A24
41	Compression Spring		
42	3/8 x 2" Machine Bolt		
43	Hanger		
44	Lever and Link		
45	Kingbolt		
46	Clevis		
47	Clamp Casting		
48	U Bolt		
49	Foot Lever Spring Eye Bolt		
50	Foot Lever Spring		



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## Striking and Finishing Device for the Hobbs Jr. Block Machine



Fig. 1

IN answer to a widespread demand for some device which would mechanically strike off and finish the back of the Hobbs block, Anchor has developed this exceedingly simple and effective attachment which will go on any Hobbs Jr. machine without drilling any holes whatever into the machine. This attachment can be placed on the machine with the use of a wrench and screwdriver by anyone in an hour or less.

Figure 3 is a phantom view of the Hobbs machine showing how the Striking and Finishing Device is mounted. In Figure 3 the hopper is thrown forward in a position ready to receive the concrete.

After the block has been tamped the lever (No. 4) is moved upward thus striking off the top of the block evenly and at any desired height above the top of the mold box.

The amount of surplus material left to be driven into the back of the block is controlled by a simple adjustment on the Striker Plate. After the block has been struck the Striking and Finishing Device is in the position shown in Figure 1.

The tamper is then thrown into operation. The first tamp foot down brings the finishing plate in a position shown in Figure 2 and it is only necessary to run the tamper an instant to finish the back of the block. This finisher plate is so arranged as to positively prevent any material from sticking to it.

As soon as the tamper is thrown out of operation the finisher is automatically thrown back into the position shown in Figure 1. This position gives plenty of room for opening the mold box and closing it again and for the insertion of facing material when such is used.



Fig. 2

This inexpensive device increases production a great deal. In addition to this it insures uniform blocks because every block is struck off at exactly the same height. The rigid finisher plate gives a true and smooth back to the blocks.

Use of this device is strongly recommended to all Hobbs Block Machine operators. It will pay for itself in an extremely short time by increasing production. In addition to this the quality and uniformity of the blocks will be much improved.

When the Striking and Finishing Device is purchased with the block machine it is shipped mounted on the machine. If you already have a Hobbs Junior and would like to mount one of these devices, proceed as follows:



Fig. 3

Remove the cold rolled strip No. 4 as shown in the repair parts guide on the Hobbs machine. If your machine has no cold rolled strip No. 4 on the back plate, it is only necessary to run a  $5\frac{1}{8}$ -inch U.S. Standard tap through the holes in the top of the back plate. Then saw off the rib which is cast on the back plate. Place the Striking and Finishing Device on the machine in the general position shown and fasten the feed table of the device to the back plate with the screws which formerly held the cold rolled strip No. 4. Then tighten the clamp, which is a part of

the straddle casting No. 8, securely to the core rod support casting of the Hobbs machine.

Next remove the lever which operates the cores of the block machine, slip on the catch release collar No. 5, and replace the core draft lever.

To adjust the catch release collar, place the Striking and Finishing Device in the position shown in Figure 1. Then tighten the catch release collar in such a position that when the front end of the cores is about  $\frac{1}{2}$  inch from the pallet, the curved rod in the catch release collar engages the catch release so that it in turn raises the catch No. 9 sufficiently to permit the feeding hopper to go forward.

You will find that with the machine at hand the instructions are easily followed, and that when the device has once been installed, it is practically fool-proof and will give very little trouble.

Gross Weight—385 lbs.

Displacement—240 cubic feet.

Code Word—"Nodool."

### Striking and Finishing Device Repair Parts List

Part Number	Name of Part	Pattern Number
1	Finisher Plate	.....
2	L. H. Finisher Plate Arm	660
3	Counterweight	669
4	Hand Lever	.....
5	Catch Release Collar	.....
6	Catch Release	544
7	Thrust Arm	530
8	Straddle Casting	500
9	Catch	725
10	Hopper	.....
11	Finisher Plate Arm	.....
	Right Hand	659
	Left Hand	660

In ordering repairs always give the serial number of your machine; also number of part desired and the pattern number if there is such. All parts of all machines are right or left as you face the machine.

## The Anchor Stripper



PLAIN-FACED blocks are constantly in demand, and their popularity is growing daily. The best and fastest way to make them is on the Anchor Stripper.

This process permits the use of an *extremely wet* mixture. All the concrete receives a direct blow from the tamper because the tamp feet completely cover the block.

Finally, to add to these advantages, the block is stripped out of the mold box. This stripping action is not only the fastest known means of delivering a block, but it is also the best. Every face is troweled perfectly.

Users of the Anchor Stripper find in it the same high grade material and accurate workmanship that have made the Hobbs Block Machine and the Anchor Tamper so favorably known.

All parts of the Stripper are accurately machined on jigs. The mold box is bolted rigidly together, thus insuring for you an absolutely true block *at all times*.

The Anchor Stripper is extremely heavily and carefully built. And like other Anchor equipment, it is simple, sturdy and low-priced to conform to the Anchor System of big production at low cost.

You will find some of the biggest plants in the country using the Anchor Stripper.

*It is made by "Anchor": It is guaranteed by the name: It will do what Anchor says it will.*

The drawing on opposite page shows the standard type of core furnished with the Anchor Stripper. The machine is made in two standard sizes: 16 and 24 inches. Each different length machine will make blocks any width of wall, such as the 8, 10 or 12 inches, by getting the necessary cores and pallets to conform with the size wall desired. All blocks  $7\frac{3}{4}$  inches high.

The standard size cores furnished with the machine give 40 per cent air space. In localities where building restrictions will not allow as great an air space as furnished with the machine, there can be furnished, when specified, a lesser percentage air space, such as 33 per cent, or any percentage of air space desired. *Anchor can also furnish any other shape of core to match pallets you already have.*

Iron pallets are used on this machine. These may be purchased from Anchor or made in your local foundry with necessary patterns.

First of all the Anchor Stripper makes a quality block. The Erie Cement Products Company, Sandusky, Ohio, writes as follows: "My Anchor Stripper is working fine and turning out the best plain block made in Erie County. Am having big sale for them and am well pleased with the machine."

These blocks can be laid either face out. They are made wet—tamped hard.

Anchor does not believe in exaggerated production claims or claims based on test run under perfect conditions and as much of this depends on the operators and facilities in handling, it is impossible to say offhand what could be done in your plant.

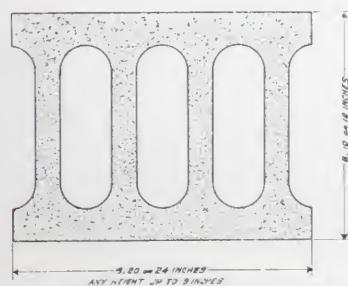
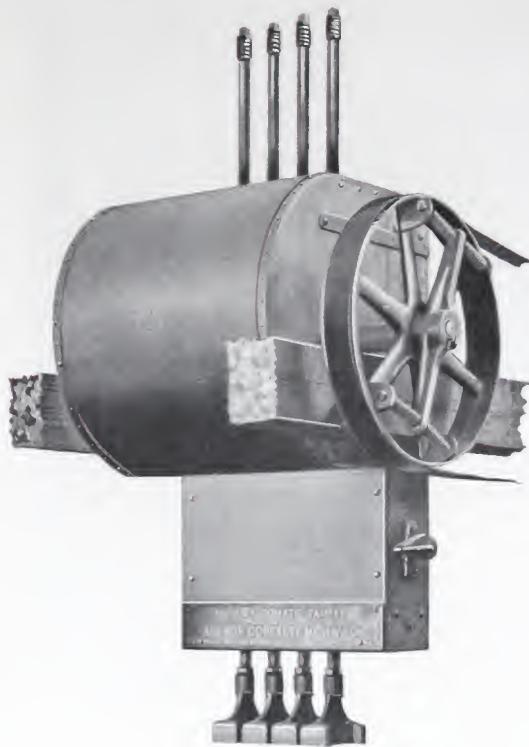
Anchor can refer you to many plants using the Anchor Stripper that are averaging 1200 to 1400 blocks per day. In fairness we must state that this is above the average but shows what can be done under good conditions.

Seventy-five per cent of blocks used in most localities are plain face. This is a practical machine for producing plain-faced blocks. A careful study of *actual* production figures shows that users of the Anchor Stripper get *more blocks per dollar* than any other equipment can give and the original investment is much less.

Make your plain blocks on *Anchor Stripper*. Your faced blocks on Hobbs face-down machines. *Buy a single unit and add as you grow.*

That's the *Anchor System*—low initial cost, profitable operation.

Every day more plants—both large and small—are learning that *in the long run*, the Anchor System pays.





Geo. Barriball, Cleveland, Ohio

Known as the cleanest and neatest products plant in U. S., is one of the oldest plants and one that is making real money—has enjoyed more editorial publicity in trade journals than any other plant. Mr. Barriball has experimented with many makes of machinery but has now settled down to Anchor equipment exclusively, makes quality products, is an Anchor booster and a money-maker.

Striking evidence of the rising popularity of plain-faced blocks may be seen in the Hoover Model "Home, Sweet Home" built recently on the Executive Grounds at Washington as the nucleus of the Better Homes in America Movement sponsored by the General Federation of Women's Clubs of the United States.

An Anchor Stripper was chosen to make the blocks used through the entire house. The Home is a charming modern reproduction of the old home-stead on Long Island where John Howard Payne wrote his immortal song, "Home, Sweet Home."

Ground for the Home was broken by Herbert Hoover, Secretary of Commerce, and the house was dedicated by the late President Harding, and was later used as an information bureau for a national Shrine convention.

As the house has been visited by thousands, Anchor equipment has thus helped to spread the gospel of concrete block and stucco construction across the country.

Surely it is a fine compliment to Anchor equipment when that equipment is chosen to furnish material for the home that is to be the national model of fine home construction at low cost. Think how forceful this fact would be in selling Anchor stripper blocks for you.

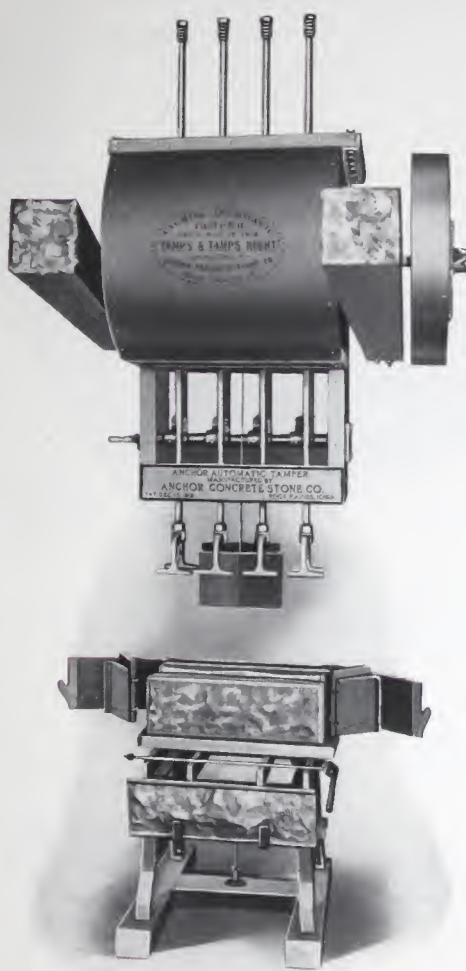
	Weight	Displacement	Cores	Code Word
Anchor	525 lbs.	14 cu. ft.	8" - 33%	Osner
			8" - 40%	Oldbo
Stripper	16"		10" - 33%	Olney
			10" - 40%	Oltut
	24"		12" - 33%	Odem
			12" - 40%	Odie
	32"		12" - 45%	Osay
Anchor	600 lbs.	18 cu. ft.	8" - 33%	Nee
			8" - 40%	Nevo
Stripper			10" - 33%	Ned
			10" - 40%	Nono
			12" - 33%	Nix
			12" - 40%	Nort
			12" - 45%	Nem

By 8-inch cores is meant cores for making blocks 8 inches wide, 10-inch cores make blocks 10 inches wide, 12-inch cores make blocks 12 inches wide.



Dedication Day. General view of Home, showing Sherman Monument and Treasury Building

## The Anchor Continuous Air-Space Block Machine



THE Anchor Continuous Air-Space Block Machine was designed to meet the insistent demand for a concrete block which was absolutely *frost and moisture-proof*.

It is a recognized principle that double wall construction is essential to a good building. And it is evident that the best way to tie these two walls together is with heavy steel ties made right into the wall itself—not laid in the mortar joints.

The Anchor Continuous Air-Space Block is the solution. Each block is tied together by four ties or anchors, which are made right into the block. These anchors are made from heavily galvanized one-quarter inch steel wire. They are five inches long with a one-inch right angle bend at each end.

You can purchase these anchors at any time from the Anchor service department which makes and furnishes them at cost. The price is usually about half a cent each.

The Anchor Continuous Air-Space Block can be laid in the wall more rapidly than any other block because there are only two surfaces upon which to spread mortar and these are wide and straight.

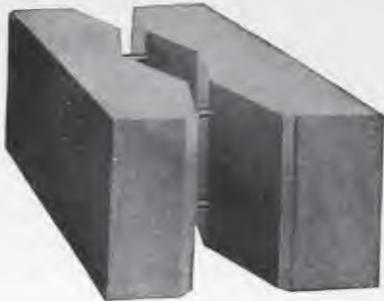
Moreover, these blocks are handled with hooks inserted beneath the anchors, which greatly increases the ease and speed of laying. The air space is  $33\frac{1}{3}$  per cent.

The Anchor Continuous Air-Space Block Machine is made in two sizes—the Standard and the Junior.

The Standard size makes blocks that lie in the wall 8 inches high, 24 inches long, and 8, 9, 10, 11 or 12 inches wide, with corners and fractionals to match.

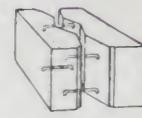
The Junior Air-Space Machine makes blocks that lie in the wall 8 inches high, 16 inches long, and 8, 9, 10, 11 or 12 inches wide, with fractionals and corners to match.

The Anchor Continuous Air-Space Block is one which appeals to home builders and to practical masons. These two things assure you of a demand for your product.



The Anchor Continuous Air-Space Block, because of its peculiar design, can be made very wet. This results in a stronger block. Another thing—all of the bearing area of each block is bearing area in the finished wall. These are no cement webs which become worthless as bearing area when placed in the wall.

With Continuous Air-Space Blocks you actually build a double wall at the cost of laying a single wall. It is safe—and common practice—to plaster directly on the inner wall of these blocks.



### The Standard Anchor Continuous Air-Space Block Machine

Complete to make plain-faced blocks with corners and fractionals to match, consists of the following parts:

1—Bench No. 10, 2 Legs	No. 19
2—Back Standards	No. 11
1—Back Plate	No. 15
1—Plain End Door, left	No. 18
1—Plain End Door, right	No. 17
1—Plain Front Plate	No. 12
1—End Core, left	No. 8 L
1—End Core, right	No. 8 R
1—Collapsible Center Core	No. 7
1—Corner Block Core	No. 1
1—Corner Core Support	No. 0
1—8-inch Corner Core Connection	No. 4
1—9-inch Corner Core Connection	No. 3
1—10-inch Corner Core Connection	No. 5
1—12-inch Corner Core Connection	No. 2
2—Front Plate Support Hooks	No. 00
1—Eccentric	No. 30
1—4-inch Cast Box for 8-inch Corners	No. 20½
1—3-inch Cast Box for 9-inch Corners	No. 20
1—2-inch Cast Box for 10-inch Corners	No. 13
1—Beveled Edge Strip for Water Table Blocks	No. 25
1—Beveled Edge Water Table, Left Corner	No. 25 L
1—Beveled Edge Water Table, Right Corner	No. 25 R
1—Sample Wood Pallet	No. XX
2—Hand Tamers	No. 6
2—Block Layers' Hooks	

#### SET OF ROCK FACE PLATES

1—Full Rock	No. 44
1—Half Rock	No. 45
1—Three Quarters Rock	No. R
1—Rock Corner Door	No. 36

#### SET OF PANEL FACE PLATES

1—Full Panel	No. 14
1—Half Panel	No. 14 A
1—Three Quarters Panel	No. P
1—Panel Corner Door	No. 16

#### SET OF HAMMERED STONE FACE PLATES

1—Full H. S.	No. 40
1—Half H. S.	No. 39
1—H. S. Corner Door	No. 38

#### SET OF BROKEN ASHLAR FACE PLATES

1—24-inch Broken Ashlar Plate used in connection with rock face plates	No. H
--	-------

Weight, complete, 650 lbs.  
Displacement for Export, 7.6 cu. ft.

Code Word—"Congo."

The  
COMPLE  
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parts:  
1—Bench  
2—Back  
1—Back  
1—Plain  
1—Plain  
1—Plain  
1—End C  
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1—Corne  
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1—Hand  
2—Front  
1—Samp  
2—Block  
1—Full R  
1—Half R  
1—Rock  
1—Full R  
1—Half R  
1—Panel  
1—16-in  
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## The Junior Anchor Continuous Air-Space Block Machine

COMPLETE to make plain face blocks with corners and fractionals to match, consists of the following parts:

1—Bench No. 66, 2 Legs.....	No. 65
2—Back Standards.....	No. 11
1—Back Plate.....	No. 63
1—Plain End Door, left.....	No. 18
1—Plain End Door, right.....	No. 17
1—Plain Front Plate.....	No. 22 L
1—End Core, left.....	No. U80
1—End Core, right.....	No. U81
1—Collapsible Center Core.....	No. U82
1—Corner Block Core.....	No. U83
1—Corner Core Support.....	No. 0
1—Corner Core Connection.....	No. 2
1—4-inch Cast Box for Corner Blocks.....	No. 67
1—Eccentric.....	No. 30
2—Hand Tamers.....	No. 6
2—Front Plate Support Hooks.....	No. 00
1—Sample Wooden Pallet.....	No. X
2—Block Layers' Hooks.....	

### SET OF ROCK FACE PLATES

1—Full Rock.....	No. 31
1—Half Rock.....	No. 61
1—Rock Corner Door.....	No. 62

### SET OF PANEL FACE PLATES

1—Full Panel.....	No. 70
1—Half Panel.....	No. 71
1—Panel Corner Door.....	No. 69

### SET OF BROKEN ASHLAR PLATES

1—16-inch Broken Ashlar Plate used in connection with rock face plates.....	No. 60
Weight, complete, 450 lbs.	
Displacement for Export, 5 2 cu. ft.	

Code word—"Gentle."



## Anchor Continuous Air-Space Silo Machine

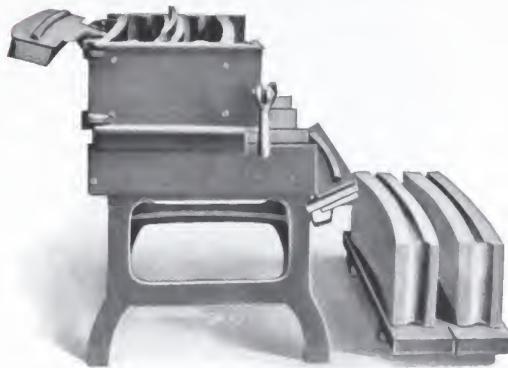
MAKES blocks that lie in a perfect 16-foot circle but can be laid in any diameter from 12 feet to 20 feet. Note the groove to receive reinforcing.

These blocks are used where an extraordinarily fine silo is required. The air space reduces freezing to a minimum. Practically no ensilage is lost through freezing in a silo of this type. While a silo made from these blocks costs more than one made from Anchor silo slabs, it costs no more than one made from ordinary silo blocks and is far superior.

16-inch Machine—Code Word "Cordelia."

24-inch Machine—Code Word "Calsin."

## Anchor Silo Slab Machine



MAKES two 4-inch silo blocks in each operation. Can be laid to the same diameters as the air space blocks.

Since two of these slabs are made at each operation they can be made very cheaply. A silo built from these slabs is fully as strong as one built from ordinary blocks and costs much less.

16-inch Machine—Code Word "Henpo."

24-inch Machine—Code Word "Loral."

This type machine but with sharper radius is furnished for making manhole and catch basin slabs.



To OWNERS of Anchor Continuous Air-Space Building Block Machines the Anchor company can furnish this equipment to make silo blocks at a very reasonable price. Either of these silo machines will operate under any Anchor tamper by merely changing the tamp feet.

The same pallets as for making building blocks are used.



THE Anchor Steel Silo Door built entirely from steel with a fiber packed door. Each door constitutes complete frame, door, and ladder for 4 feet of silo height.



THE silo shown above is located on Lakewood Farm, six miles southwest of Rock Rapids, Ia. It is 50 feet high, 16 feet in diameter and holds 250 tons. This silo is constructed from the Anchor 4-inch silo slabs and is equipped with Anchor All-Steel Silo Doors. It has been full twelve times and there is not a leak or a cracked block in it. This type is the most economical silo made.



THE blocks in the above corncrib were made with attachments on the Standard Anchor Block Machine. Two of these blocks are made in one operation. Each block contains three full holes and two half holes, giving 25 per cent open area. A ventilating shaft in the center provides perfect ventilation. This crib is 18 feet in diameter, 24 feet in height, and holds 2,500 bushels of corn.

## Anchor Concrete Brick Machines

### Made in Two Types—Face-Up and Face-Down

THE day of concrete brick has arrived. Because it can be produced at high speed and at low cost, because of its excellence as a building material, and because it can be laid more cheaply, it is fast replacing the old-style clay brick.

When properly made, concrete brick runs higher in compression and lower in absorption than clay brick. Another advantage is the uniformity of concrete brick—every one can be made exactly alike on Anchor Brick Machines. No kiln baking is necessary—no shrinkage or warping takes place.

Because Anchor Brick are uniform in size and have sharp, clean corners, masons will lay approximately 20 per cent more Anchor bricks than others in a day.

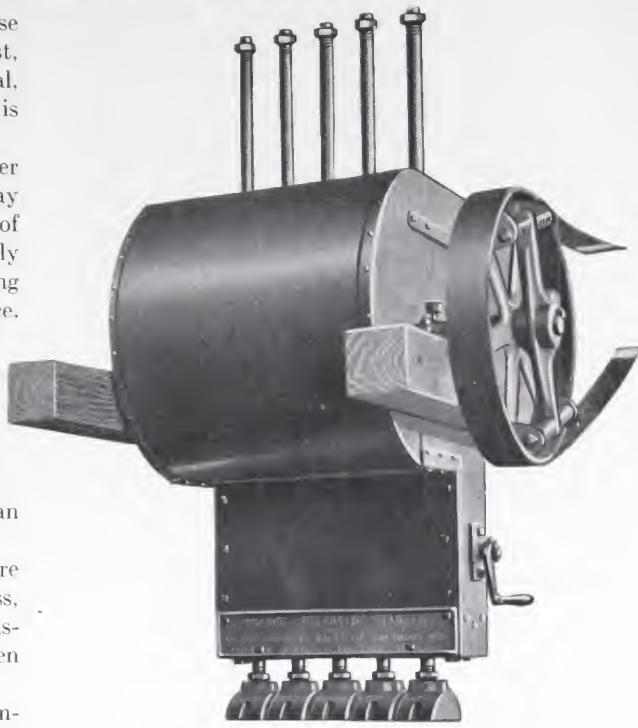
Uniformity of Anchor Concrete Brick also means double the manufacturing output of usable brick—production at far lower cost than clay brick.

It will pay you to investigate the manufacture of concrete brick. It's a big-money business, easy to start; a fast-growing, permanent industry. Your production is sure to be profitable when you use Anchor machines.

When the plant of the Adamantex Brick Company, of Baltimore, Md., was built and put into operation by the Cemprod Engineering and Construction Company, New York, Anchor machines were installed. During more than a year's operation its daily output was more than 100,000 bricks.

So efficient, so sturdy, so trouble-proof has this Anchor equipment been under continuous heavy duty that the Cemprod Engineering Company has since equipped another and still larger plant at Philadelphia—the largest concrete brick plant in the world—with Anchor brick machinery *exclusively*. The success and rapid expansion of this and other Anchor brick plants prove that there is big money in the manufacture of Anchor Concrete Brick.

*A quick, inexpensive way to get into the Concrete Brick business is to follow the Anchor System—Buy a Single Unit and add as you grow.*



Anchor Face-Down Brick Machine with Anchor Automatic Power Tamper

### Anchor Concrete Brick Machines—Continued

ANCHOR Concrete Brick Machines are made in two distinct types—Face-Up and Face-Down. Both types have proved their efficiency and dependability under hard, continuous service.

The Anchor Face-Down Machine is the fastest machine in the world for making common brick. Both machines will use either wood or pressed steel pallets. Either machine will be supplied with hand or power tamper. The hand-tamped machine can quickly be converted into a power machine simply by changing the tamper. The machines with the power tampers are the same as those with the hand tampers attached, except for the tamping device itself.

Standard machines make ten bricks— $2\frac{1}{4}$  by  $3\frac{3}{4}$  by 8 inches in size, at each operation. Machines for making other sizes of brick will be built to your specifications.

#### Exclusive Features of Anchor Power Brick Machines

- (1) Anchor Brick machines are small single units—no large investment required to start making concrete brick. As your business increases, add more machines. With any number of workers, your production of concrete brick is profitable under the safe and sound Anchor System of small units.
- (2) Anchor Brick Machines can be used under the famous Anchor Tamper—faster production.
- (3) Both machines are equipped with rigid feed table and heavy sliding hopper with adjustable cut-off plate.
- (4) All dividing plates are cyanide hardened to prevent wear.
- (5) Heavy housed bases—able to stand knocks and blows.
- (6) All parts are machined in accurate jigs to assure perfect brick. Repair parts, should they be necessary, will fit without alterations.



Anchor Face-Down Brick Machine with Hand Tamper

	Gross Weight	Displacement	Code Word
Anchor Face-Down Machine with Hand Tamper	600 lbs.	17.30 cu. ft.	Hurdle
Anchor Face-Down Machine for use with Power Tamper	425 lbs.	17.30 cu. ft.	Hurdle
Anchor Face-Up Machine with Hand Tamper	600 lbs.	27.25 cu. ft.	Actro
Anchor Face-Up Machine for use with Power Tamper	425 lbs.	27.25 cu. ft.	Duelo

## Anchor Face-Down Machine

THE Anchor Face-Down Machine—as the name indicates—makes the brick with the face down.

The mold box has a polished steel face upon which the facing material is scattered. The coarse aggregate is pounded into the facing, insuring a perfect bond and a dense face.

A rough or mottled face brick can be made on this machine by treating the face after brick are taken from the machine.

After the brick are tamped, the hopper is pushed back, striking off the surplus concrete, which is carried back to the feed table. There is no waste. The pallet is then slipped into place, the bricks are

given a half turn and carried away to their rack. The mold box is closed in an instant by merely throwing bed plate back into position.

One reason for the surprising speed of this machine is the simple and efficient device for holding the pallet while the brick are being turned over. There are no triggers, catches or springs. No other machine has so practical and fast a means of delivering the brick from the mold box.

The Anchor Face-Down Machine is the most popular brick machine in the country. It is the fastest machine for making common brick and yet beautiful brick can be easily made on it.

## Anchor Face-Up Machine

THE Anchor Face-Up Machine is used when it is desired to apply a face by floating, troweling or brushing it on. This machine makes the brick in the same position in which they are carried away.

Like the Face-Down Machine this machine has a hopper which strikes off the surplus material after the brick are tamped, carrying it back on the feed table. To open the mold box, simply apply a slight pressure on the foot lever, and at the same time push the hand lever through a short range. This movement carries all the dividing plates straight back and swings the front plate down, leaving the brick in a position from which they are easily picked up and carried away.

For straight-run face brick—only one edge faced—the facing is applied before the lever is thrown. When making header brick—one edge and one end faced—remove one bolt just inside the front housing and apply a short lever. This enables the operator to swing the front plate down and apply facing on the ends before the dividing plates are drawn.

Past performance of this machine proves that it is unquestionably the best built and the most practical face-up brick machine. It is primarily a faced-brick machine, but will make common brick rapidly enough for profitable production.



Anchor Face-Up Brick Machine with Hand Tamper

amper  
Code Word  
Hoodle  
Hurdle  
Actro  
Dualo

## The Famous Anchor Automatic Power Tamper

### "Tamps and Tamps Right"

For years the Anchor Tamper has been standard equipment over every type and make of block, brick, tile and stave machine. There are more Anchor Tamers in operation than all other makes combined.

In all sections of the country you will find it in operation over every brand of block machine. The reason is simple. The Anchor Tamper so increases the output of any machine—block, brick, tile or stave—that it soon pays for itself.

Added profits soon return the cost of the Anchor Tamper to its owner. In addition to increased profits, the Anchor Tamper makes a denser, stronger and more uniform product.

The Anchor Automatic Tamper requires no floor space because it is mounted directly over the mold box. No extra workman is required to operate it. It has only one lever. The man who operates the mold box can throw it in and out of operation in a second. The Anchor Tamper does its work while the workmen are filling the mold box, thus requiring no additional time for the tamping operation, and saving a large amount of time.

With the Anchor Automatic Tamper blocks can be made from a much wetter mixture, and are uniformly and firmly packed; thereby producing a block that is much stronger, cheaper and more waterproof than is possible by any other system.

The Anchor Tamper is the *one* power tamper that is simple enough in construction to be practical. It is rapid in operation and requires only one horse power. And it is so simple in design that it is seldom in need of repairs.

The fact that there are more Anchor Tamers in operation than all other makes combined is eloquent evidence that the Anchor Tamper, like other Anchor equipment, is dependable, that it is built to do its work right, and that it makes money for its owner.



## How the Anchor Tamper Is Built

THE improved tamper frame is now hot-riveted. The tamp rods have been increased in size from one-inch to 1½-inch diameter which entirely eliminates all possibility of breakage.

The Anchor Tamper has an improved crank-shaft construction. The tamping shafts are raised by heavy annealed steel crank arms, fastened in place on the driving shaft with a half-inch steel key and also securely clamped by means of a split hub.

Improved tamp rod bushings now provide for take-up.

The new and extremely simple Anchor brake device is so cleverly constructed that it throws each tamping rod in and out of operation in exact time and, in addition to this, when the tamper is thrown out of operation an eccentric automatically lifts all tamp rods clear of the crank arms so that virtually no power is used when block is being taken from mold box.

Much of the success of the Anchor Tamper is due to the use of the special patented Shock-Absorber Pulley—another exclusive Anchor feature.

This drive pulley, 26 inches in diameter, is equipped with four heavy springs, thereby transmitting the power evenly through the crankshaft to the crank arms and preventing crystallization of steel parts. In addition to the easement produced by the shock absorber, the part of the crank arms coming in contact with lifting guides is equipped with fiber rollers, further aiding in prevention of crystallization of steel parts.

The fact that all working parts are fiber against steel—not steel against steel—means that noise is reduced to a minimum and no oiling is necessary.

Compared with other tampers the Anchor Automatic Tamper is noiseless. All working parts are completely housed in permanent steel covers and thus kept free from dust. The enclosed working parts are all equipped with fiber rollers requiring no oil or other attention. The only parts requiring oil are the main crankshaft bearings.

Anchor superior construction consisting of steel dust-proof tampers equipped with shock absorbers, timers and fiber rollers makes this the most practical and profitable tamper to operate.

The Anchor Tamper more than doubles your output, and increases the density and uniformity of your product. If you are tamping by hand, or with an inferior tamper, you are losing money every day. Let us show you in figures how much you can save by using the Anchor Tamper—the tamper of dependable and unequaled performance.

	Gross Weight	Displacement	Code Word
Tamper to fit Hobbs Jr. ....	900 lbs.	78.5	Kane
Tamper to fit Hobbs Sr. ....	1050 lbs.	78.5	Kar
Tamper to fit 16" Anchor Stripper.....	900 lbs.	78.5	Kelso
Tamper to fit 24" Anchor Stripper.....	1075 lbs.	78.5	Kardol
Tamper to fit 16" Continuous Air-Space Machine ....	900 lbs.	78.5	Kapoot
Tamper to fit 24" Continuous Air-Space Machine.....	1059 lbs.	78.5	Katyl
Tamper to fit either Anchor Brick Machine.....	950 lbs.	78.5	Kenmon

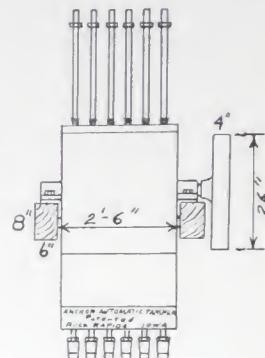
Information on tampers to fit any other machines on request.



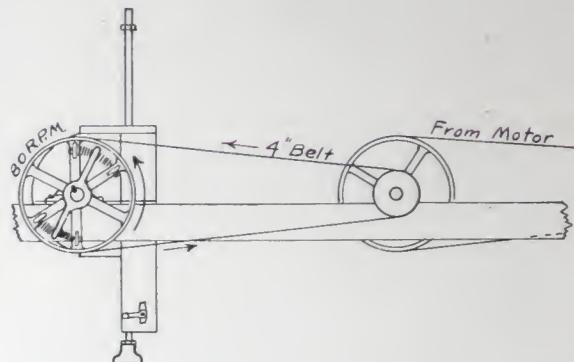
A typical money-making small plant—A Hobbs Jr. and an Anchor Stripper, both with sturdy Anchor Tampers

## Instructions for Installation and Operation of the Anchor Automatic Power Tamper

For slave tampers hang timbers 2 feet 10 inches apart instead of 2 feet 6 inches as shown in sketch



FRONT VIEW



SIDE VIEW

THIS drawing shows how the Anchor Automatic Tamper is hung. You will note that no floor space is required. The timbers on which the Anchor Tamper rests can be hung from the ceiling or supported by posts placed far enough from the machine to be out of the way. Be sure that the structure on which the Anchor Tamper rests is rigidly braced and does not vibrate excessively.

### Height of Anchor Tamper

An installation blueprint accompanies each tamper. For a side-face machine or stripper machine, the tamp feet, when in their lowest position, should go into the mold box about three inches.

For face-down machines, the bottom of the tamper feet should reach to the bottom of the cores.

For shallow mold boxes using hoppers, such as brick machines and silo stave machines, the tamp feet should not go into the mold box more than one inch. Be sure to hang the Anchor Tamper at the proper height. If you find it is too high to tamp the blocks properly you can easily raise the block machine a trifle or lower the tamper slightly.

### Speed of Pulley Wheel

The pulley wheel should run from 75 to 85 revolutions per minute. Do not run the Anchor Tamper too fast. The Anchor Company cannot be responsible for breakages in cases where the Anchor Tamper is run more than 85 revolutions per minute.

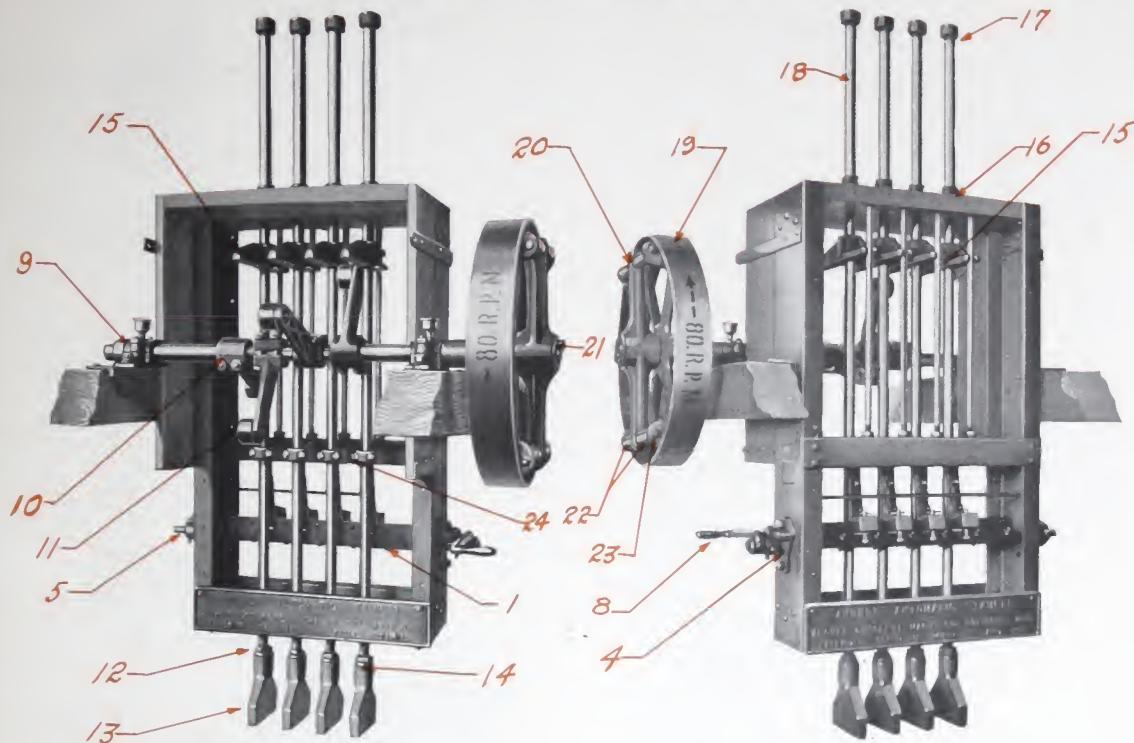
### Oiling

Oil *nothing* except the crankshaft bearings, which are on the outside of the housing. Oil placed elsewhere on the Anchor Tamper will reach fiber parts and cause them to disintegrate. Do not allow the Anchor Tamper to stand outdoors or under a leaky roof, as water will also ruin the fiber parts.

Treat your Anchor Tamper properly and it will give you good service. Go over it occasionally and tighten all nuts, especially the lock nuts on the tamp feet. In ordering repair parts, be sure and give part number and description as listed on page 45.

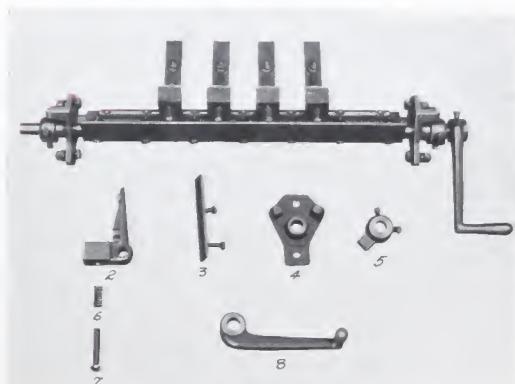
If there is anything regarding the installation or operation of your Anchor Tamper which you do not fully understand, do not hesitate to write us.

## Tamper Repair Parts List



No. 1—Complete Brake Assembly  
 No. 2—Brake Shield Casting  
 No. 3—Brake Shield—with Bolts  
 No. 4—Brake Box  
 No. 5—Stop Collar  
 No. 6—Brake Spring  
 No. 7—Brake Spring Rivet  
 No. 8—Starting Handle  
 No. 9—1 3/4" Pillow Block  
 No. 10—Crank Arm—Split Hub  
 No. 11—Rawhide Rollers  
 No. 12—1 1/4" Jamb Nut  
 No. 13—Tamp Foot  
 No. 14—1 1/4" Spring Washer  
 No. 15—Lifting Guide  
 No. 16—Safety Spring  
 No. 17—Safety Collar  
 No. 18—Tamp Rod  
 No. 19—Pulley  
 No. 20—Shock Absorber Cross Arm

No. 21—Cross Arm Key  
 No. 22—Shock Absorber Springs  
 No. 23—Shock Absorber Bolt 1/2 x 13"  
 No. 24—Brake Collar



## The Anchor High-Test Tile Machine

IN these days of high prices anything that will reduce the cost of construction is eagerly sought by builders.

That explains why Anchor High-Test Tile is the best selling tile made, and why owners of Anchor High-Test Tile Machines find their business growing rapidly.

Anchor High-Test Tile can be manufactured at a cost that compares favorably with any other type of building unit. But the big saving is in the cost of laying.

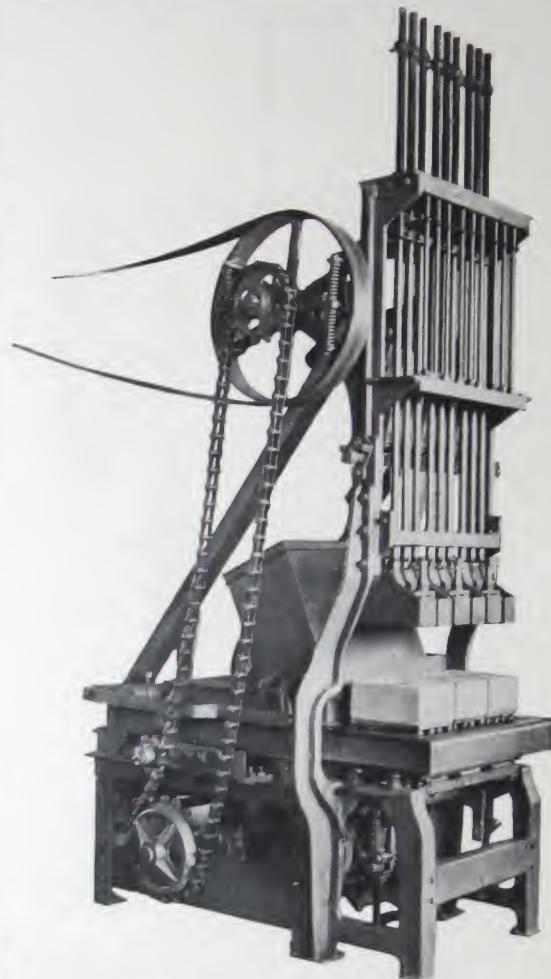
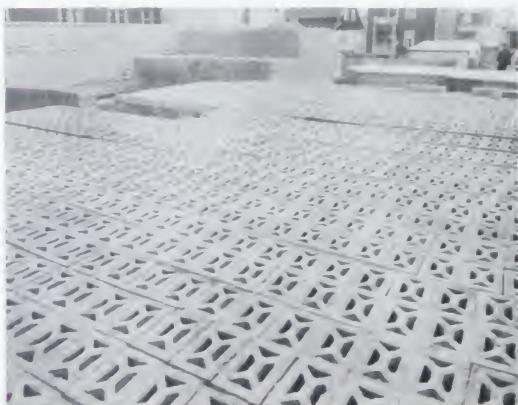
Actual tests have shown that a mason in an ordinary day's work will lay three times as much wall volume with High-Test Tile as he can lay with brick. As a result, the cost of laying a wall is substantially reduced, when High-Test Tile is used.

Anchor High-Test Tile gives the builder:

- (a) *Low Cost*
- (b) *Maximum Strength*
- (c) *Minimum Weight*
- (d) *Low Moisture Absorption*
- (e) *Economy in Handling*
- (f) *Correct Design*
- (g) *Constant Uniformity*
- (h) *Wide Adaptability*

Anchor High-Test Tile Machines give you:

- (a) *Increased Business*
- (b) *Growing Profits*



### High-Test Tile and Stucco

*High-Test* tile and stucco make an excellent form of housing construction, a type universally approved.

The permanent bond obtained, the low moisture absorption of the tile, and the smooth wall surface secured through the use of the perfectly formed units all tend to make an ideal structure that is permanent, beautiful and economical to build. Stucco, properly applied to *High-Test* tile, will not crack or peel.

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## Anchor High-Test Tile Machines Give You Advantages of a Wet Mixture

THE design of the *High-Test* tile with the partitions extending from top to bottom permits the use of a wet, quaky mixture. The strongest concrete will result from using sufficient water to produce a stiff, plastic mixture. Such a mixture is easily stripped off the *High-Test* cores, and the side walls are smoothly troweled by the sides of the mold box.

This peculiar patented design of *High-Test* tile is also largely responsible for their extraordinary strength, and in addition it provides a perfect handhold for laying the block in the wall.

Anchor *High-Test* tile are produced at a remarkably low cost because of the simplicity and dependability of the Anchor machine. The simple and sturdy design of the Anchor machine means steady, sure output and freedom from costly delays due to breakdowns and adjustments.

*High-Test* tile can be made with plain or corrugated faces. A perfect bond with stucco, plaster or mortar is obtained with either face.

### The Anchor High-Test Tile Machine is Built for Service

The Anchor *High-Test* tile machine is constructed to deliver its product at a profit to the owner.

Every detail of the construction of these machines is the result of long study and experiment and no expense has been spared to obtain the best of materials and workmanship.

The result is a reliable, trouble-proof machine, that may be depended upon for continuous production. The construction is simple and rugged, and all parts are guaranteed against defects for a period of one year. All machines are given an actual running test before shipment.

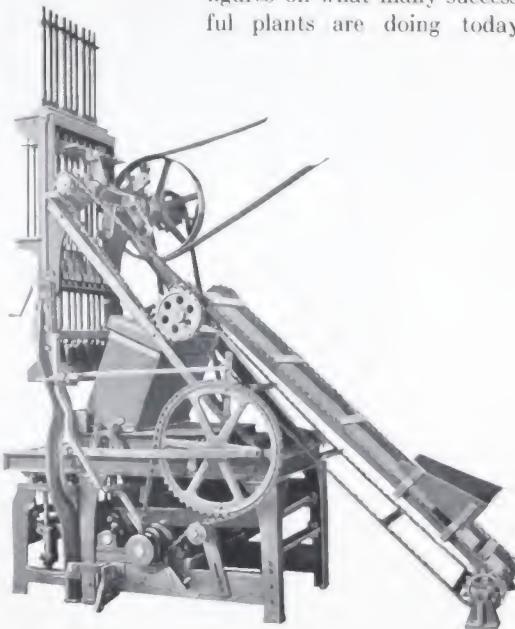
Regular equipment provides for the manufacture of three light weight tile, 5 by 8 by 12. With a slight change in cores and tamps the operator can readily fit up the same machine to make 5 by

4 by 12, 5 by 6 by 8, and 5 by 8 by 10 tile for corners, partitions and window and door jambs.

This modern machine is entirely automatic and especially speedy. It eliminates all hand labor except the removal of the tile from the machine. Three full-size tile or six half-tile are made at each operation.

*The Anchor High-Test Tile Machine is not an experimental machine. Every High-Test owner is a satisfied user.*

Investigation will prove to you that there is a sound money-making opportunity in the manufacture of *High-Test* tile. Let Anchor give you figures on what many successful plants are doing today.



Anchor High-Test Tile Machine Complete to Make the Following Sizes:	Gross Weight	Displace- ment	Code Word
5 x 7 $\frac{3}{4}$ x 11 $\frac{3}{4}$	5000 lbs.	275 ft.	Sord
5 x 3 $\frac{3}{4}$ x 11 $\frac{3}{4}$			
5 x 5 $\frac{3}{4}$ x 7 $\frac{3}{4}$			
5 x 7 $\frac{3}{4}$ x 9 $\frac{3}{4}$			

# STRUCTURAL MATERIALS RESEARCH LABORATORY

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CO-OPERATION OF  
**PORTLAND CEMENT ASSOCIATION**  
 AND  
**LEWIS INSTITUTE**

## TESTS OF CONCRETE BUILDING TILE

"The samples - - - - - are today (Sept. 23, 1920) just fourteen days old, and were taken from the regular production of Barriball Bros., of Cleveland. Made of a 1 to 4 mixture, run of bank sand which contains a small proportion of loam. Four hours in steam curing rooms."

The tile had triangular shaped vertical openings as they are laid in the wall. The exterior walls and cross webs were slightly tapered from a thickness of about 1 inch at bottom to within about  $\frac{3}{4}$  inches of the top. At this point there was a shoulder giving the walls a thickness of about  $1\frac{1}{8}$  inches.

Three tile were tested for compressive strength and three for absorption, at the age of 28 days.

The compression tests were made in a 200,000-lb. Olsen universal testing machine. The bearing surfaces of the specimens were capped with a mixture of gypsum and neat cement to insure an even distribution of load. The load was applied through a spherical bearing block.

The tile for the absorption test were dried to constant weight and immersed in water at room temperature for 48 hours. The absorption is the gain in weight expressed as a per cent of the weight.

Tile identified by our Lot No. 5101.

Tile Loaded No.	face inches	Dimension of			Compressive Strength Absorp.				
		Tile in sur- face inches		Gross Minumum Height inches	Total Area sq. in.	in lbs. per sq. in.	Over Gross Area	Over Min. Area	48 Hrs. by wgt.
		inches	sq. in.	in. sq. in.	lbs.	in lbs.	Area	Area	
1	11.87 by 7.75	4.75	92	43.6	105630	1150	2170	—	—
2	11.87 by 7.75	4.75	92	48.6	104170	1130	2140	—	—
3	11.87 by 7.75	4.75	92	48.6	112130	1220	2300	—	—
4	11.87 by 7.75	4.75	92	48.6	—	—	—	—	6.6
5	11.87 by 7.75	4.75	92	48.6	—	—	—	—	6.3
6	11.87 by 7.75	4.75	92	48.6	—	—	—	—	6.2
		Av. 107330			1170		2200		6.4

Correct

*S. Walker*

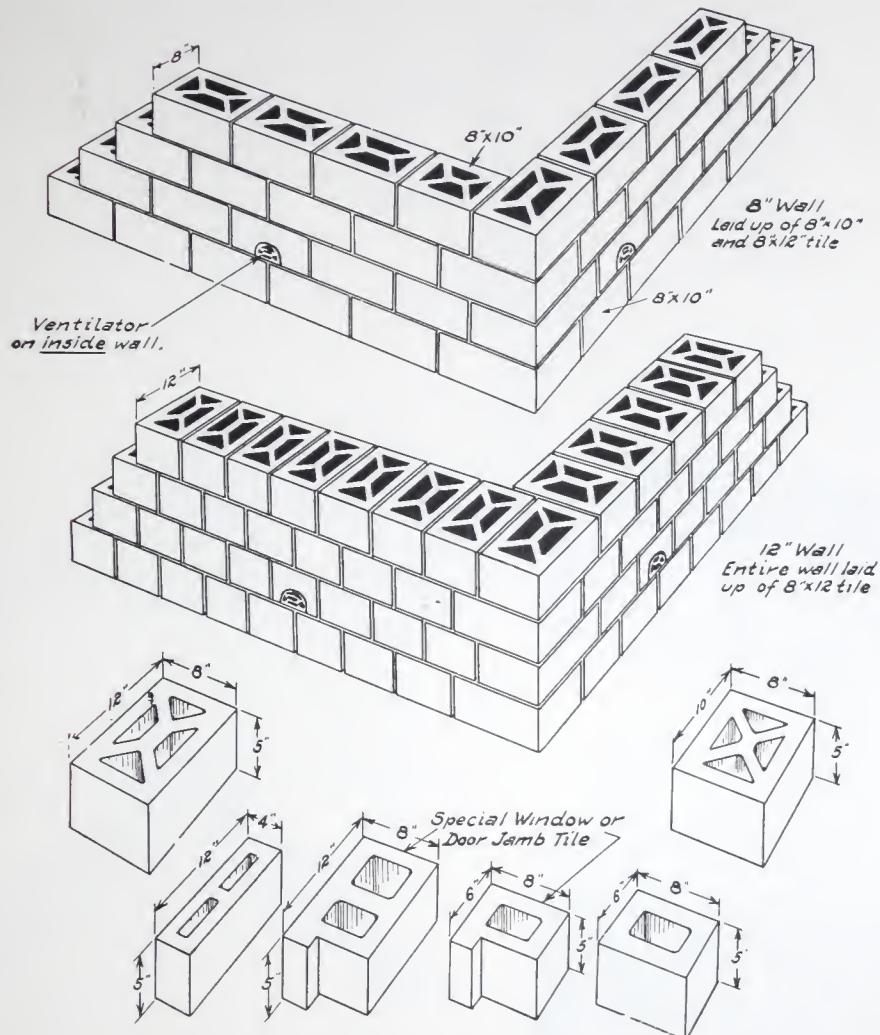
Approved

*H. A. Abrams*

Professor in Charge of Laboratory.

November 10, 1920

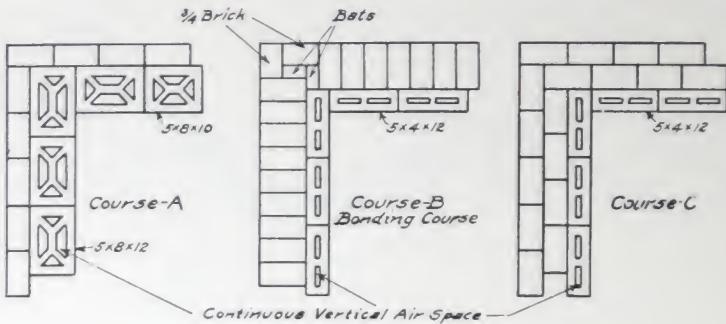
## Showing Anchor HIGH-TEST Tile Construction



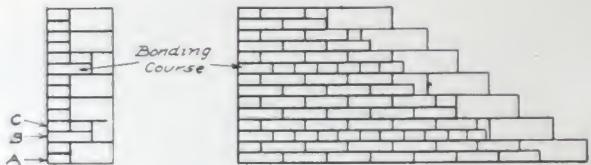
The several sizes of Anchor HIGH-TEST Tile lend themselves to any type of construction



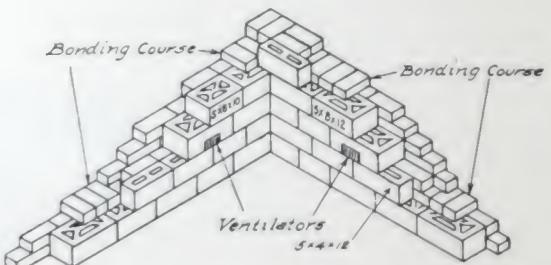
## Showing Anchor HIGH-TEST Tile Construction



Top View—Showing wide mortar bed and perfect handhold



Bottom View



Brick bond perfectly with Anchor HIGH-TEST Tile

## The Walter Concretile Machine

WALTER Concretile is the roofing material of the future. Every day sees the demand for it increasing.

The reason is that Walter Concretile is an ideal roofing material—fire-proof, storm-proof, and water-proof. Besides, it is permanent and it retains its striking beauty throughout its many years of service.

The increasing tendency is to use tile roofing for all kinds of buildings. Its greater permanence and moderate price make it practical for the modest cottage as well as the most expensive home, for public buildings, for garages, barns—anything that has a roof.

Tile manufacturing is a profitable business—and the safest, soundest way of building up a tile business is to make and sell Walter Concretile.

With little capital and no experience in tile making you can start manufacturing Walter Concretile. Anchor service makes sure that your tile business will be profitable right from the start. If desired, Anchor will furnish an expert demonstrator at nominal cost. He teaches your men the correct methods of making, handling, curing, stacking and laying the tile. If Anchor blueprints are followed, the Walter machines can immediately be put into operation.

### Big Production at Low Cost With the New Improved Portable Walter Concretile Machine

The new improved portable Walter Concretile Machine now makes it possible for Concretile manufacturers to speed production, cut down costs and turn out better tile than with the stationary type of machine.

It's the only portable tile manufacturing machine on the market. It has many exclusive advantages that mean easier tile sales with bigger profits.

The portability feature of this machine saves thousands of steps daily for each operator. It means less waste motion—more time for actual production. Steps are saved in two ways—the operator moves his machine as the work progresses so the tile racks to be filled are always convenient.

Empty pallets are also always handy. Tile are taken off the pallet 24 hours after the tile are made and these empty pallets are stacked alongside the row of racks. As the machine is moved, these stacks of pallets are within easy reach.

Not only does the operator save thousands of steps, but he avoids the energy-sapping work of *carrying two to three tons of material daily*. Figure it out—each tile weighs five pounds, pallet seven pounds—12 pounds to each time. Each operator turns out 400 to 500 tile in a day.

Think of the heavy carrying avoided in addition to time saved, then you will appreciate what Anchor has accomplished by building this new,



portable Concretile machine. No stationary machine can begin to compete with it in output.

Nor can any other machine produce tile that has proved so eminently satisfactory. Portability of the machine in itself adds to the quality of the product.

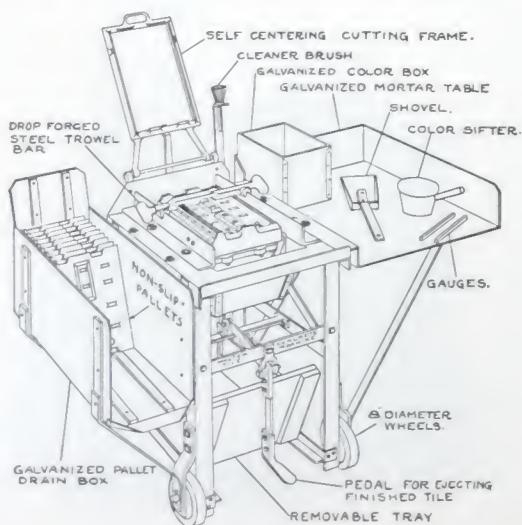
There is less handling of the tile—no shaking, jarring, disintegrating of the tile in delivering it from the machine to rack. This is bound to happen where the newly-made tile is hauled on a truck, even though the floor is level and smooth.

### Walter Concretile Specifications

Weight of each tile ..... 5 pounds  
 Surface exposed to weather ..... 8 x 12 inches  
 Number of Concretile per 100  
 square feet ..... 150  
 Weight per square, including  
 ridge rolls, etc. ..... 800 pounds

Roof tile have been made with these same over-all dimensions for hundreds of years in other countries. It has always been impractical to make pallets or molds for tile of greater size. Large pallet molds are too heavy and clumsy to handle and they generally warp when cast.

### The New, Portable Concrete Machine



### Superior Features of the New Walter Concretile Pallet



Note the improved pallet shown here. The non-slip cleats are *an exclusive, patented Walter feature*.

The cleats grip the concrete and prevent it from slipping as the concrete is pressed and worked into form with the trowel bar. This gripping action of the nonslipping cleats, combined with the high compression of the specially designed trowel bar, produces a tile of extreme density. Walter Concretile made on cleated pallets show practically no water absorption in use. The result? Tile made on these improved, cleated pallets are 18 per cent *stronger* than tile manufactured on the old style, smooth-faced pallets. And remember—*only Walter Pallets are cleated*.

### Walter Concretile Roofs Quickly and Accurately Laid

You can positively depend on Concretile to fit accurately and lay smoothly. It forms a perfect roof, because every tile is uniform in weight and dimensions, and warping is absolutely eliminated. Concretile has straight edges that interlock accurately, making a smooth, perfect-fitting joint.

Two patented "buttons" on pallets mold indentations in the tile for nailing tile to the roof when necessary. Where these buttons are formed the concrete is thin so the nails can easily be jabbed through.

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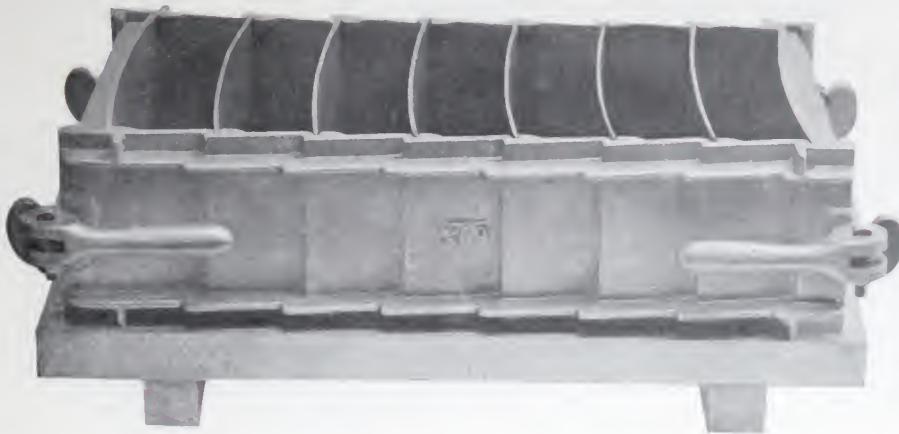
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## Equipment Section

### The Anchor Special Circle Cistern Brick Hand Mold



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THE Anchor Special Circle Cistern Brick Mold makes seven circle brick at each operation, size 3 by 6 by 12 inches. Each brick is equal in size to four common brick.

The brick make a perfect 8-foot circle. By varying them slightly any desired circle can be made.

One thin coat of cement plaster will make a cistern water-tight, saving more than half the cost to the user.

These brick can be laid in the wall much faster than ordinary brick.

Any common pallet that is 12 by 24 inches or larger can be used with this mold.

The brick can be made by the wet process at a six to one mix, using your coarse material.

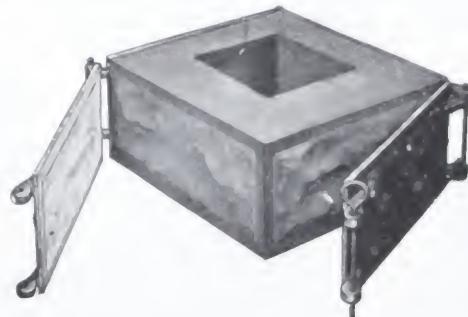
The machine is made from the finest of castings and steel plates and is positively guaranteed.

#### Porch and Chimney Hand Molds

Every block maker should have a set of Porch and Chimney Molds. They are well built and low in price. Can be operated on a bench on any plain

pallet or on the floor. The rock face designs are carefully selected and are pleasing in appearance.

The following sizes are available for prompt shipment:



Rock Face with  $\frac{1}{2}$ -inch Smooth Margin Edge, Smooth Face and Beveled Panel Design:

Height	Size	Height	Size
$7\frac{3}{4}$ "	8 x 8"	$3\frac{3}{4}$ "	12 x 12"
$7\frac{3}{4}$ "	10 x 10"	$3\frac{3}{4}$ "	14 x 14"
$7\frac{3}{4}$ "	12 x 12"	$3\frac{3}{4}$ "	16 x 16"
$7\frac{3}{4}$ "	14 x 14"	$3\frac{3}{4}$ "	18 x 18"
$7\frac{3}{4}$ "	16 x 16"	$3\frac{3}{4}$ "	20 x 20"
$7\frac{3}{4}$ "	20 x 20"		

The following molds in Rock Face and Smooth Face:

## The Multiplex Chimney Block Machine

THE Multiplex Chimney Block Machine is the only one on the market that turns out blocks which will make an absolutely fire-proof chimney.

Advantages of Multiplex blocks are numerous. They give the chimney a rounded flue, perfectly smooth inside. This gives it a perfect draft so that you can burn any kind of soft coal without clogging it with creosote. These chimneys never need cleaning, because the perfect draft keeps them clean.

The ventilating chambers are outside the lining of the flue, and are superheated by the heat passing up the chimney. This causes air to pass up through the ventilating chambers, and airs the house.

The ventilators, or air shafts, are so constructed that registers may be added to the flue, to give perfect ventilation and not interfere with the smoke draft in the least.

A small register, say 4 by 8 inches, placed in your chimney near the floor, will take all the cold and foul air off the floor and keep the floor warm. With this system you can warm your house in one-half the usual time, and save much fuel.

PRICES QUOTED UPON APPLICATION.

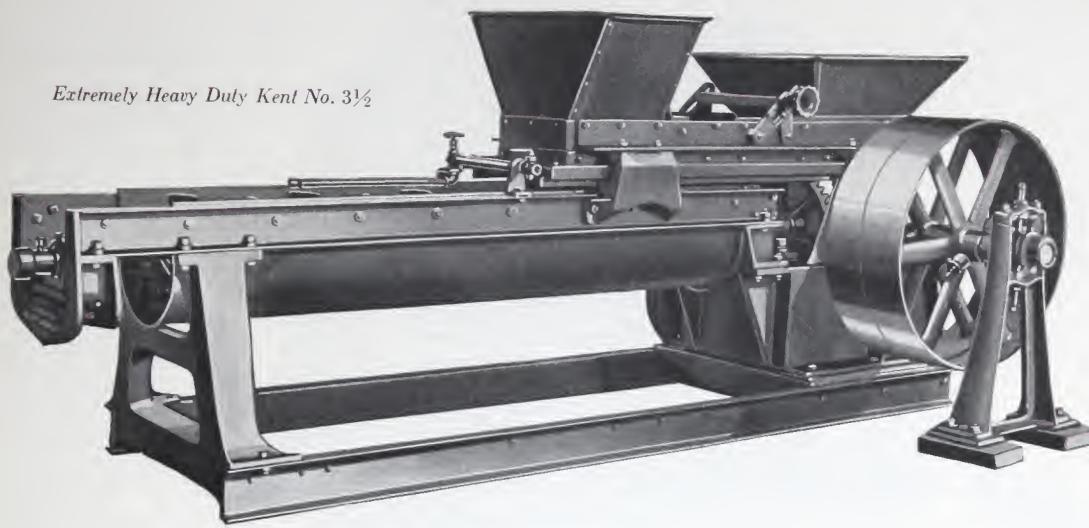


*This view represents a chimney built with Multiplex chimney blocks, showing the round smoke flue. Also the ventilating chambers are shown with tongues and grooves, and how the blocks are laid in the wall.*



## The Kent Continuous Mixer

*Extremely Heavy Duty Kent No. 3½*



### Does the Work Automatically

THE Kent Continuous Mixer does everything automatically. It operates entirely by itself. Unlike batch mixers, it requires no labor beyond the loading operation.

Keep the hopper filled with sand and cement and the Kent automatically will serve your block machine's charging platform a continuous stream of perfectly mixed and moistened material.

To keep the hoppers filled, most users of Kent machines construct big wood or metal bins over the hoppers. With the bins filled, the mixer will run on by itself for hours, requiring no attention whatsoever. This frees your men for actual molding work.

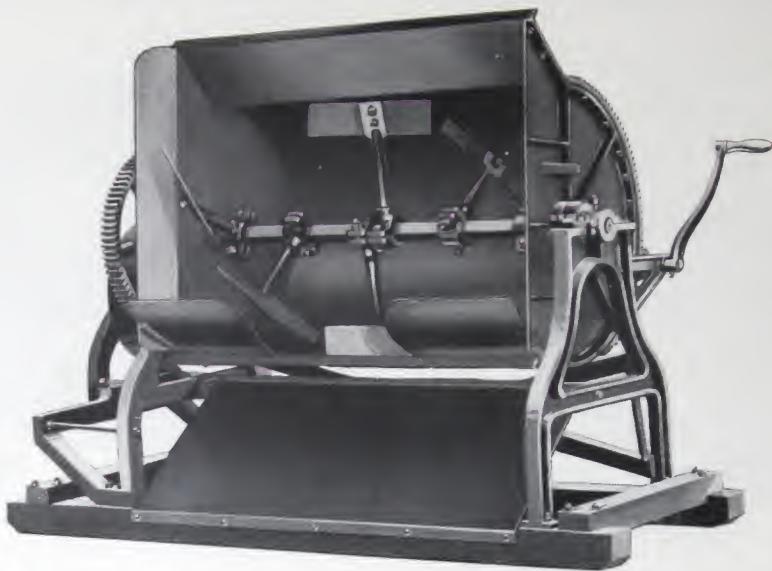
With wages mounting, the Kent will save you money.



*Standard No. 2½ Kent*

PRICES QUOTED UPON APPLICATION.

## The Blystone Batch Mixer



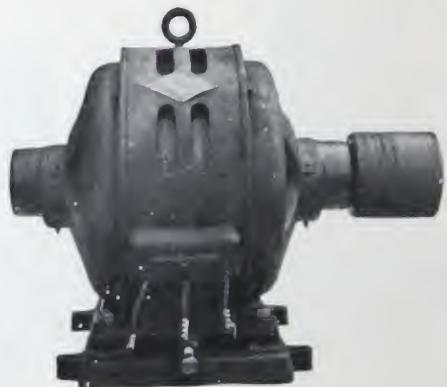
**BLYSTONE** Batch Mixers have been on the market for many years and have given unusual satisfaction.

The cut shows the Blystone Batch Mixer, mounted on skids for shop use, in operating position; it is in this position that the machine is discharged. The mixer is charged while the machine is in motion without delay or stopping, by use of a platform, 18 to 20 inches high, built beside the machine, from which the material can be dumped from a wheelbarrow into the mixing drum.

The mixing drum is so carefully constructed and accurately balanced that the dumping operation is extremely simple, easy to perform and never failing in its action. Three turns of the crank handle to the right, and three back, accomplishes the dumping and the machine is then ready for the next batch. There is nothing connected with this dumping arrangement to get out of order, and no time is lost in its operation.

Power discharge device can also be furnished. This mixer is made in 7 sizes ranging from 2 to 14 cubic feet capacity.

### Motors



Direct and Alternating Current.

Single and Three-Phase.

PRICES QUOTED UPON APPLICATION.

## Elevators

### Anchor Improved Drag Elevator

A DRAG Elevator is usually more practical in a concrete products plant than any other type of elevator.

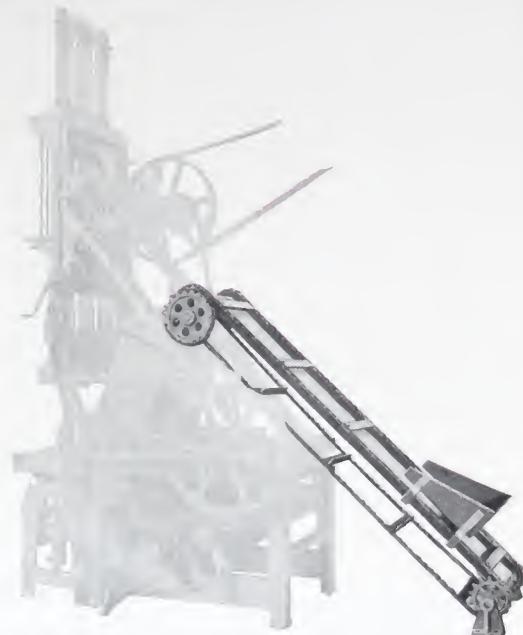
Many drag elevators, however, have disadvantages which make them objectionable. In Anchor Improved Drag Elevator the undesirable features heretofore found in this type have been eliminated. A study of the illustration reveals an elevator which is substantial and practical; one that can be applied in almost any plant under any conditions.

Anchor elevators are heavily built. The main frames are heavy 3 by 3-inch angles; the bed is 10-gauge steel. The head and foot equipment is extremely sturdy. The chain is No. 62 and the cross members are 2 by 2-inch angle.

The elevator is driven from the head through back gears. It may be driven by a chain or belt from either the line shaft or other countershaft.

An important feature of the Anchor elevator is that it drags with the *top* chain—not the bottom one, as is commonly done. This means that in feeding the hopper or hood at the foot of the elevator it is not necessary to put all the material through the moving top chain, thereby scattering the material and often clogging the elevator. The Anchor elevator never clogs.

Another desirable feature of the Anchor elevator is the fact that the chains never run in or through the concrete or material being elevated. The chains are always above and outside the trough. This is important.



The standard width of the trough is 16 inches. Other widths can be furnished when specified. When ordering or asking for quotations always give the distance between the centers of the head and foot sprockets; specify what size sprocket or pulley you wish furnished on the head shaft.

The Anchor Drag Elevator is a simple, heavily built machine which is sold at a reasonable price.



Adamantex Brick Co., Baltimore, Md. In operation more than a year with daily capacity of 100,000 bricks. Operate

twelve Anchor face-down brick machines and power tampers. One of largest cement brick plants in the world

## Anchor Roller-Bearing One-Man Car for Blocks or Bricks

STYLE 10 is the Anchor special car for handling 16-inch block. The ends are rigid with deck sections which are easily handled by one man.

The car is mounted on Oil Tempered Springs, Roller Bearing Wheels. Length of car, 86 inches; height of car, 12 inches; distance between decks, 12 inches; distance lengthwise between deck legs, 78 inches.

This car is made in two sizes, 24 inches wide and 30 inches wide. The 24-inch car has a 24-inch track gauge and the 30-inch car has either 24-inch or 30-inch track gauge.

In ordering always specify the width of car and track gauge wanted. The 30-inch car is recommended as it allows more space between the blocks in the center.

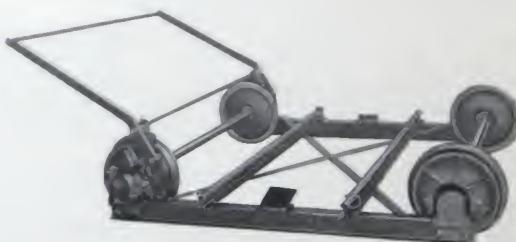


*A modern curing room showing fine track system*

### The Anchor Roller-Bearing Transfer Car

#### With Pulling Bail and Brake

STYLE 20, No. 1, is the Anchor standard transfer car and is furnished with pulling bail and brake. This device makes it more convenient for handling, allows the operator to stop the car at any point, the brake holding it in that position without the trouble of locking the car, which otherwise would be necessary.



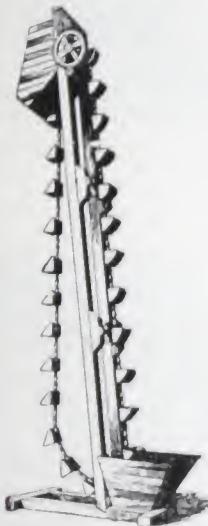
## Standard Bucket Elevator

STANDARD Bucket Elevator can be supplied in any length desired.

No. 110 Hercules Chain and 10 by 6-inch Malleable Buckets are used on these elevators unless otherwise specified.

Always give the number of feet centers when ordering. Supports are furnished by the purchaser.

Maximum Size Pieces—Not to be larger than 3½-inch cubes and the amount of such pieces should not exceed 10 per cent of the whole. When maximum size pieces exceeds 10 per cent of whole, use Elevator 1216.



Capacity—35.0 tons per hour of sand and gravel or similar material. Buckets 80 per cent level full.

Bucket—10 by 6-inch Malleable Bucket, Style A.

Chain—110 Her., K-2 Attachment, pitch 6.00 inch, working strength 3900 lbs., speed 200 feet per minute.

Horse power—3.1 at countershaft for 40-foot centers.

Approximate Shipping Weight—Machinery, Terminals, 860 pounds. Elevator per foot centers exclusive of supports, 26 pounds. Prices upon application.

## The Six Points of the Anchor

USERS of concrete machinery have found that six points of the Anchor Line make it stand out above all others. These six are: Simplicity, Durability, Efficiency, Economy, Service, and Guarantee.

In brief, Anchor equipment—

- (a) *Is simple in design,*
- (b) *Stands hard usage,*
- (c) *Does uniform high-grade work,*
- (d) *Turns out profitable quantities,*
- (e) *Brings factory co-operation,*
- (f) *Is guaranteed.*



*The perfect handhold on each High-Test tile means that these tiles are easily and rapidly laid. The mason keeps his trouée in his hand at all times*

## Ornamental Molds

THE Anchor Company can furnish fancy and ornamental molds of every description. If interested in such equipment write for special

catalog. To do first class ornamental work it is absolutely necessary that you have the very finest molds.



*View of Exhibit Adamantez Brick Company at Builders' Show, Baltimore, Md.*



*View of Exhibit Miller-Nelson, Inc., at Builders' Show, Baltimore, Md.*



*Examples of Modern Homes from Concrete Blocks*

## Quality the Watchword

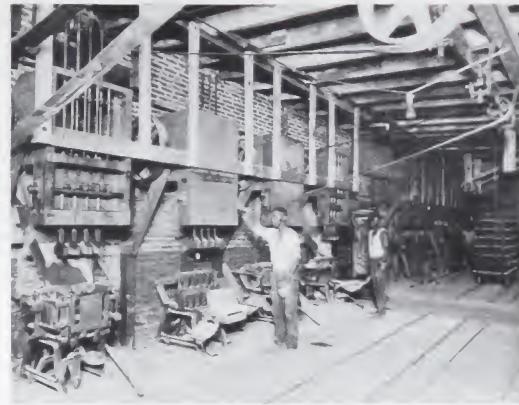
By WALLACE R. HARRIS

President, National Concrete Products Association  
Editor, "Concrete Products" Magazine

QUALITY should be the watchword in every concrete products plant. To overcome competition, members of this young but rapidly growing industry should realize that the sale of poor products creates a sales resistance hard to overcome.

Good equipment must be supplemented by good materials and good workmanship. Brains must be employed in the concrete industry. If a poor product is made, the equipment should not be blamed. Investigation will probably show that the trouble lies in the aggregate, the lack of water in the concrete mix or in the curing. It is rare that the cement is at fault as all cement manufacturers strive to maintain a quality higher than the standards set for the cement industry.

Organic matter in the sand is often the troublesome factor. The colorimetric test can be applied and the presence of organic matter ascertained. In such event it is well to find another source of supply. If limestone screenings are used as coarse aggregate, fine dust should be eliminated as, in some limestones, the flour-like dust is detrimental to quality. Pebbles, commonly termed gravel, should be free from soft shale or lumps of clay or other matter not hard and tough in character. All aggregate should be well graded to avoid wasting cement.



The cement content should be in the amount required to produce the desired strength, density or waterproofness of the products being manufactured. The cement requires a definite quantity of water for its crystallization, termed hydration. This water should be incorporated in the concrete mixture. Curing in a moist, warm atmosphere will accelerate the hydration of the cement and will result in a stronger product. Cold water should not be used as mixing water. It is good practice in cold weather to warm the water before adding it to the materials in the mixer. It is not necessary to use hot water, in fact this should be avoided. Water about 100 degrees F. will be sufficiently warm.

It is also necessary that aggregate be warmed in winter work. It matters not that the machines be under cover in a warm room if cold, ice-filled aggregate is brought in from the outside. All concrete materials should be warm and thus promote the chemical action necessary to result in complete crystallization of the cement content.

Steam curing is coming more into use as time passes.

Certificates of Quality are issued by the Concrete Products Association and have been used by





operators of concrete products plants to increase their sales. To get a Certificate of Quality, it is necessary that membership be held in a state branch of the Concrete Products Association or in the parent body as members at large where state branches have not been organized.

Specimen products are selected by a representative of the Association, sealed and shipped by the maker to a designated testing laboratory. If the products are found to meet the requirements of the American Concrete Institute Standards a Certificate is issued together with report of tests. These have been used effectively to prove that quality products are on the market. It should be realized that these papers can be used to kill malicious propaganda directed against concrete products in general.

Machinery manufacturers are striving to improve their machines and realize that their prosperity depends on the development and prosperity of the concrete products industry. The machinery men have donated generously to proj-

ects designed to promote the best interests of the concrete products industry.

Those entering the industry should realize that a reward for honest workmanship awaits them. Thought and hard work will, in a properly equipped products plant, result in success.

The building industry is flourishing and will continue to boom for many years to come before homes equal the ever increasing demand. Those selling high-grade concrete building units may well feel proud of the part they are playing in the construction of durable, sanitary, comfortable and beautiful homes sufficient for the humble wage earner or for the moneyed man who desires a fire-safe mansion.

The Concrete Products Industry is here to stay and pioneers of brains, energy, initiative and perseverance will develop with the industry and will prosper according to their respective merits. The world wants safe homes. The industry can furnish the materials necessary for high class buildings of any type.

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PRESERVATION  
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TECHNOLOGY  
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